

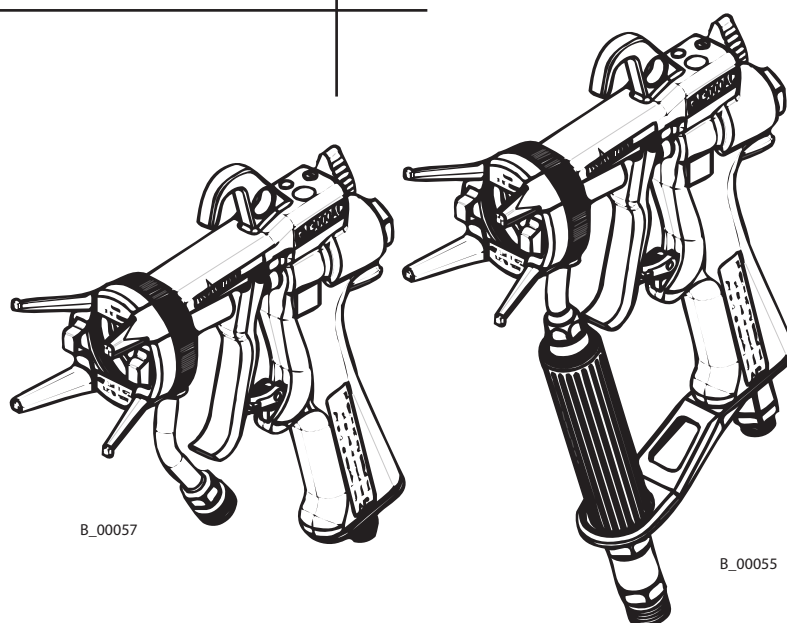
WAGNER

Translation of the original
Operating manual

GM 3000AC

Edition 05/2007

AirCoat spray gun
with flat or round jet nozzles



CE  II 2G X (Atex 95)

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1 ABOUT THESE INSTRUCTIONS

This operating manual contains information on the operation, repair and maintenance of the unit.

→ Always observe these instructions when operating the unit.

This equipment can be dangerous if it is not operated in accordance with this manual.

Compliance with these instructions constitutes an integral component of the warranty agreement.

1.1 LANGUAGES


This operating manual is available in the following languages:

Language:	Part No.	Language:	Part No.
German	364830	English	364831
French	364832	Dutch	364833
Italian	364834	Spanish	364835
Danish	364836	Swedish	364837
Portuguese	364838	Polish	364839


1.2 WARNINGS, NOTES AND SYMBOLS IN THESE INSTRUCTIONS

Warning instructions in this manual point out particular dangers to users and equipment and state measures for avoiding the hazard. These warning instructions fall into the following categories:


Danger - imminent danger. Non-observance will result in death, serious injury and serious material damage.

 SIHI_0100_GB	⚠ DANGER
	<p>This line warns of the hazard ! Possible consequences of failing to observe the warning instructions. The signal word points out the hazard level.</p> <p>→ The measures for preventing the hazard and its consequences.</p>


Warning - possible danger. Non-observance can result in death, serious injury and serious material damage.

 SIHI_0103_GB	⚠ WARNING
	<p>This line warns of the hazard ! Possible consequences of failing to observe the warning instructions. The signal word points out the hazard level.</p> <p>→ The measures for preventing the hazard and its consequences.</p>

Caution - a possibly hazardous situation. Non-observance can result in minor injury.

 SIHI_0101_GB	⚠ CAUTION
	<p>This line warns of the hazard ! Possible consequences of failing to observe the warning instructions. The signal word points out the hazard level.</p> <p>→ The measures for preventing the hazard and its consequences.</p>

Caution - a possibly hazardous situation. Non-observance can cause material damage.

 SIHI_0102_GB	CAUTION
	<p>This line warns of the hazard ! Possible consequences of failing to observe the warning instructions. The signal word points out the hazard level.</p> <p>→ The measures for preventing the hazard and its consequences.</p>

Note - provide information on particular characteristics and how to proceed.

2 GENERAL SAFETY INSTRUCTIONS

2.1 SAFETY INSTRUCTIONS FOR THE OPERATOR

- Keep these operating instructions to hand near the unit at all times.
- Always follow local regulations concerning occupational safety and accident prevention.



2.1.1 ELECTRICAL EQUIPMENT

Electrical plant and unit

- To be provided in accordance with the local safety requirements with regard to the operating mode and ambient influences.
- May only be maintained by skilled electricians or under their supervision.
- Must be operated in accordance with the safety regulations and electrotechnical regulations.
- Must be repaired immediately in the event of problems.
- Must be put out of operation if they pose a hazard.
- Must be de-energized before work is commenced on active parts. Inform staff about planned work, observe electrical safety regulations.

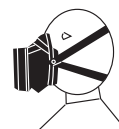


2.1.2 PERSONNEL QUALIFICATIONS

- Ensure that the unit is operated and repaired only by trained persons.

2.1.3 A SAFE WORK ENVIRONMENT

- Ensure that the floor of the working area is anti-static in accordance with EN 50053 Part 1, §7-2, measurement in accordance with DIN 51953.
- Ensure that all persons within the working area wear anti-static shoes, e.g. shoes with leather soles.
- Ensure that during spraying, persons wear anti-static gloves so that they are earthed via the handle of the spray gun.
- Customer to provide paint mist extraction systems conforming to local regulations.
- Ensure that the following components of a safe working environment are available:
 - Material/air hoses adapted to the working pressure
 - Personal safety equipment (breathing and skin protection)
- Ensure that there are no ignition sources such as naked flame, glowing wires or hot surfaces in the vicinity. Do not smoke.



2.2 SAFETY INSTRUCTIONS FOR STAFF

- Always follow the information in these instructions, particularly the general safety instructions and the warning instructions.
- Always follow local regulations concerning occupational safety and accident prevention.



2.2.1 SAFE HANDLING OF WAGNER SPRAY UNITS

The spray jet is under pressure and can cause dangerous injuries.

Avoid injection of paint or cleaning agents:

- Never point the spray gun at people.
- Never reach into the spray jet.
- Before all work on the unit, in the event of work interruptions and functional faults:
 - Switch off the energy/compressed air supply.
 - Secure the spray gun against actuation.
 - Relieve the pressure from the spray gun and unit.
 - By functional faults: Identify and correct the problem, proceed as described in chap. „Trouble shooting“.

In the event of skin injuries caused by paint or cleaning agents:

- Note down the paint or cleaning agent that you have been using.
- Consult a doctor immediately.

Avoid danger of injury through recoil forces:

- Ensure that you have a firm footing when operating the spray gun.
- Only hold the spray gun briefly in any one position.

**2.2.2 EARTH THE UNIT**

Electrostatic charges can occur on the unit due to the electrostatic charge and the flow speed involved in spraying. These can cause sparks and flames upon discharge.

- Ensure that the unit is earthed for every spraying operation.
- Earth the workpieces to be coated.
- Ensure that all persons inside the working area are earthed, e.g. that they are wearing antistatic shoes.
- When spraying, wear antistatic gloves to earth yourself via the spray gun handle.

**2.2.3 MATERIAL HOSES**

- Ensure that the hose material is chemically resistant to the sprayed materials.
- Ensure that the material hose is suitable for the pressure generated in the unit.
- Ensure that the following information is visible on the high-pressure hose:
 - Manufacturer
 - Permissible operating overpressure
 - Date of manufacture.
- The electrical resistance of the complete high-pressure hose must be less than 1 MOhm.



2.2.4 CLEANING

- De-energize the unit electrically.
- Disconnect the pneumatic supply line.
- Relieve the pressure from the unit.
- Ensure that the flash point of the cleaning agent is at least 5 K above the ambient temperature.
- To clean, use only solvent-free cloths and brushes. Never use hard objects or spray on cleaning agents with a gun.

An explosive gas/air mixture forms in closed containers.

- When cleaning units with solvents, never spray into a closed container.
- Earth the container.



2.2.5 HANDLING HAZARDOUS LIQUIDS, VARNISHES AND PAINTS

- When preparing or working with paint and when cleaning the unit, follow the working instructions of the manufacturer of the paints, solvents and cleaning agents being used.
- Take the specified protective measures, in particular wear safety goggles, protective clothing and gloves, as well as hand protection cream if necessary.
- Use a mask or breathing apparatus if necessary.
- For sufficient health and environmental safety: Operate the unit in a spray booth or on a spraying wall with the ventilation (extraction) switched on.
- Wear suitable protective clothing when working with hot materials.



2.2.6 TOUCHING HOT SURFACES

- Touch hot surfaces only if you are wearing protective gloves.
- When operating the unit with a coating material with a temperature of >43°C; 109.4°F:
 - Identify the unit with a warning label that says „Warning - hot surface“.

**Order No.**

9998910 Information label

9998911 Safety label

2.3 CORRECT USE

WAGNER accepts no liability for any damage arising from incorrect use.

- Use the unit only to work with the materials recommended by WAGNER.
- Operate the unit only as an entire unit.
- Do not deactivate safety equipment.
- Use only WAGNER original spare parts and accessories.



2.4 USE IN AN EXPLOSION HAZARD AREA

2.4.1 CORRECT USE

The unit is suitable for working liquid materials in accordance with the classification into explosion classes.

2.4.2 EXPLOSION PROTECTION IDENTIFICATION

As defined in the Directive 94/9/CE (ATEX 95), the unit is suitable for use in areas where there is an explosion hazard.



- CE: Communautés Européennes
Ex: Symbol for explosion protection
II: Unit class II
2: Category 2 (Zone 1)
G: Ex-atmosphere gas
X: Special identification.



2.4.3 MAX. SURFACE TEMPERATURE

The unit's maximum surface temperature depends on the temperature of the coating material.

The unit is suitable for coating materials with a max. temperature of 80°C; 176°F.

Ambient temperature

Permissible ambient temperature +5°C to +40°C; +41°F to +104°F.

2.4.4 SAFETY INSTRUCTIONS

Safe handling of WAGNER spray units

Mechanical sparks can form if the unit comes into contact with metal.

In an explosive atmosphere:

- Do not knock or push the unit against steel or rusty iron.
- Do not drop the spray gun.
- Use only tools that are made of a permitted material.

Ignition temperature of the coating material

- Ensure that the ignition temperature of the coating material is above the maximum surface temperature.

Medium supporting atomizing

- To atomize the material, use only weakly oxidizing gases, e.g. air.

Cleaning

If there are deposits on the surfaces, the unit may form electrostatic charges. Flames or sparks can form if there is a discharge.

- Remove deposits from the surfaces to maintain conductivity.

2.5 GERMAN REGULATIONS AND GUIDELINES

- a) BGV D15 Working with liquid ejection devices
- b) BGV D25 Using coating materials
- c) CHV 9 Regulations on flammable liquids
- d) BGR 104 Explosion protection rules
- e) BGR 132 Avoiding ignition risks
- f) BGR 180 Setting up for cleaning with solvents for cleaning workpieces with solvents
- g) ZH 1/406 Guidelines for liquid ejection devices
- h) BGI 740 Painting rooms and equipment

Note: All titles can be ordered from Heymanns Publishing House in Cologne or download from Internet

3 PRODUCT LIABILITY AND WARRANTY

3.1 IMPORTANT NOTES ON PRODUCT LIABILITY

As a result of an EC regulation, effective as from January 1, 1990, the manufacturer shall only be liable for his product if all parts come from him or are approved by him, and if the devices are properly fitted, operated and maintained.

If other makes of accessory and spare parts are used, the manufacturer's liability could be fully or partially null and void.

The usage of original WAGNER accessories and spare parts guarantees that all safety regulations are observed.

3.2 WARRANTY

This unit is covered by our warranty on the following terms:

We will at our discretion repair or replace free of charge all parts which within 24 months in single-shift, 12 months in 2-shift or 6 months in 3-shift operation from date of receipt by the Purchaser are found to be wholly or substantially unusable due to causes prior to the sale, in particular faulty design, defective materials or poor workmanship.

The terms of the warranty are met at our discretion by the repair or replacement of the unit or parts thereof. The resulting costs, in particular shipping charges, road tolls, labour and material costs will be borne by us except where these costs are increased due to the subsequent shipment of the unit to a location other than the address of the purchaser.

This warranty does not cover damage caused by:

Unsuitable or improper use, faulty installation or commissioning by the purchaser or a third party, normal wear, negligent handling, defective maintenance, unsuitable coating products, substitute materials and the action of chemical, electrochemical or electrical agents, except when the damage is attributable to us.

Abrasive coating products such as redlead, emulsions, glazes, liquid abrasives, zinc dust paints and similar reduce the service life of valves, packings, spray guns, nozzles, cylinders, pistons etc. Any wear resulting from the aforementioned causes is not covered by this warranty.

Components not manufactured by Wagner are subject to the warranty terms of the original maker.

The replacement of a part does not extend the warranty period of the unit.

The unit should be inspected immediately upon receipt.

To avoid loss warranty, any apparent defect should be notified to us or the dealer in writing within 14 days from date of sale of the unit.

The right to commission warranty services to a third party is reserved.

Warranty claims are subject to proof of purchase by submitting an invoice or delivery note.

If an inspection finds damage not covered by the present warranty, the repair will be carried out at the expense of the purchaser.

Note that this warranty does not in any way restrict legally entitled claims or those contractually agreed to in our general terms and conditions.

3.3 CE-CONFORMITY

Herewith we declare that the supplied version of



0364001	Spray gun GM 3000AC Filter M16x1.5 HV
0364002	Spray gun GM 3000AC Filter NPS1/4" HV
0364003	Spray gun GM 3000AC M16x1.5 HV
0364004	Spray gun GM 3000AC NPS1/4" HV
0364005	Spray gun GM 3000AC Filter M16x1.5 LV
0364006	Spray gun GM 3000AC Filter NPS1/4" LV
0364007	Spray gun GM 3000AC M16x1.5 LV
0364008	Spray gun GM 3000AC NPS1/4" LV
0364016	Spray gun GM 3000AC 160 bar Filter NPS1/4" LV
0364018	Spray gun GM 3000AC 160 bar NPS1/4" LV
0364020	Spray gun GM 3000AC-H M16x1.5 HV

Complies with the following provisions applying to it:

98/37/EG
94/9/EG

Applied standards, in particular:

EN 292-1	EN 1127-1
EN 292-2	EN 1953
EN 563	EN 3746
EN 1050	EN 13463-1

Applied national technical standards and specifications, in particular:
see chapter. 2.5

CE Certificate of Conformity

The certificate is enclosed with this product. The certificate of conformity can be reordered from your WAGNER representative, quoting the product and serial number.

Part number:

GM 3000AC 0364900_a



4 DESCRIPTION

4.1 AREA OF APPLICATION, USING IN ACCORDANCE WITH THE INSTRUCTIONS

The gun is suitable for atomising liquid materials, particularly coating materials, using the AirCoat process.

4.1.1 PROCESSABLE MATERIALS

Top-coat paints, primer paints, corrosion protection solvents, textured paints, lyes, staining solvents, clear paints, parting solvents, etc. on a solvent or water basis

	 WARNING
	<p>Hot coating substances! Burns</p> <ul style="list-style-type: none"> → Wear antistatic protective gloves. → When operating the unit with a coating material with a temperature greater than 43°C; 109.4°F: Identify the unit with a warning sticker "Warning - hot surface".

SIHI_0019_GB

Note:

In the event of application problems, contact your WAGNER branch and the paint manufacturer.

4.2 SCOPE OF SUPPLY

The AirCoat gun is available in different variants as shown below. In accessories different flat nozzles and round jet nozzles are available. The nozzle size depends on the paint and on the application. Therefore the nozzle is not included in the scope of supply. For a nozzle list and other accessories look in chapter 9.

4.2.1 HV-VARIANTS

These guns have a blue air cap. This air cap is specially designed for high viscosity (HV) material.

Qty	Part-No.	AirCoat gun
1	0364001	GM 3000AC with filter + M16x1.5" material connector HV
1	0364002	GM 3000AC with filter + NPSM1/4" material connectors HV
1	0364030	GM 3000AC with filter + NPSM1/4" material connector HV USA
1	0364003	GM 3000AC without filter + M16x1.5" material connector HV
1	0364004	GM 3000AC without filter + NPSM1/4" material connector HV
1	0364031	GM 3000AC with filter + NPSM1/4" material connector HV USA

4.2.2 LV-VARIANTS

These guns have a red air cap. This air cap is specially designed for low viscosity (LV) material.

Qty	Part-No.	AirCoat gun
1	0364005	GM 3000AC with filter + M16x1.5" material connector LV
1	0364006	GM 3000AC with filter + NPSM1/4" material connector LV
1	0364032	GM 3000AC with filter + NPSM1/4" material connector LV USA
1	0364007	GM 3000AC without filter + M16x1.5" material connector LV
1	0364008	GM 3000AC without filter + NPSM1/4" material connector LV
1	0364033	GM 3000AC with filter + NPSM1/4" material connector LV USA

4.2.3 HOT SPRAYING HV-VARIANTS

These guns have a blue air cap. This air cap is specially designed for high viscosity (HV) material and for hot spraying.

Qty	Part-No.	AirCoat gun
1	0364020	GM 3000AC-H without filter + M16x1.5 material connector HV

4.2.4 LV-VARIANTS 160 BAR; 16 MPA; 2320 PSI

These guns have a red air cap. This air cap is specially designed for low viscosity (LV) material.

Qty	Part-No.	AirCoat gun
1	0364016	GM 3000AC 16 MPa; 160 bar; 2320 psi with filter + NPSM1/4" material connector LV
1	0364034	GM 3000AC 16 MPa; 160 bar; 2320 psi with filter + NPSM1/4" material connector LV USA
1	0364018	GM 3000AC 16 MPa; 160 bar; 2320 psi without filter + NPSM1/4" material connector LV
1	0364035	GM 3000AC 16 MPa; 160 bar; 2320 psi without filter + NPSM1/4" material connector LV USA

4.2.5 STANDARD EQUIPMENT

The standard equipment includes:

Quantity											Part No.	Description
0364001	0364002	0364003	0364004	0364005	0364006	0364007	0364008	0364020	0364016	0364018		AirCoat manual gun GM 3000AC
1	1	1	1	1	1	1	1	1	1	1	8780111	Double-ended open-jaw spanner 13x17
1	1	1	1	1	1	1	1	1	1	1	9991401	Double-ended open-jaw spanner 17x19
-	-	-	-	1	1	-	-	-	1	-	0043235	Push-in filtre yellow (installed: push-in filtre red)
1	1	-	-	-	-	-	-	-	-	-	0034383	Push-in filtre red (installed: push-in filtre yellow)
1	1	1	1	-	-	-	-	1	-	-	0364911	Air cap HV (blue)
-	-	-	-	1	1	1	1	-	1	1	0364910	Air cap HV (red)
1	1	1	1	1	1	1	1	1	1	1	0364900	CE-Declaration of Conformity
1	1	1	1	1	1	1	1	1	1	1	364830	Operating manual German
1	1	1	1	1	1	1	1	1	1	1	see 1.0	An operating manual in the local language

The standard equipment includes:

Quantity						Part No.	Description
0364030	0364031	0364032	0364033	0364034	0364035		AirCoat manual gun GM 3000AC USA
1	1	1	1	1	1	8780111	Double-ended open-jaw spanner 13x17
1	1	1	1	1	1	9991401	Double-ended open-jaw spanner 17x19
-	-	1	-	-	-	0043235	Push-in filtre yellow (installed: push-in filtre red)
1	-	-	-	1	-	0034383	Push-in filtre red (installed: push-in filtre yellow)
1	1	-	-	-	-	0364911	Air cap HV (blue)
-	-	1	1	1	1	0364910	Air cap HV (red)
1	1	1	1	1	1	0364900	CE-Declaration of Conformity
1	1	1	1	1	1	364831	Operating manual English
1	1	1	1	1	1	see 1.0	An operating manual in the local language

For special versions the delivery note applies.

4.3 DATA

4.3.1 MATERIALS OF PAINT WETTED PARTS

Steel		Plastics		
Tungsten carbide	Stainl. steel 1.4305	UHMW-PE	FPM	PA 6.6
Stainl. steel 1.4310	Stainl. steel 1.4104	PTFE	POM	

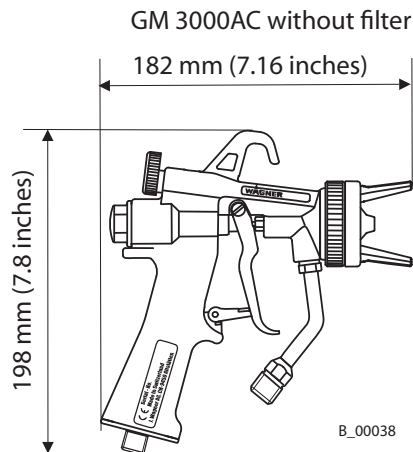
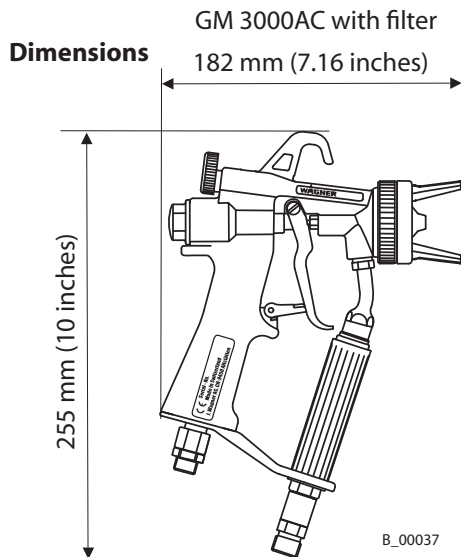
4.3 TECHNICAL DATA

Description	Units	0364001	0364002	0364003	0364004	0364030	0364031	0364005	0364006	0364007	0364008	0364032	0364033	0364020	0364016	0364018	0364034	0364035
		Max. air pressure	MPa	0.8														
	psi	120																
	bar	8																
Max. material pressure	MPa	25													16			
	psi	3625													2320			
	bar	250													160			
Mat. flow volume	l/min cc/min.	*																
Materia connector M16x1.5	mm	x	-	x	-	-	-	x	-	x	-	-	-	x	-	-	-	-
Material connector NPS 1/4"	Inches	-	x	-	x			-	x	-	x			-	x			
Air connection	Inches	G1/4"																
Filter (accessory)	Meshes	**	**	-	-	**	-	**	**	-	-	**	-	-	**	-	**	-
Weight	g	723	723	520	520	723	520	723	723	520	520	723	520	520	723	520	723	520
	oz	25.5	25.5	18.3	18.3	25.5	18.3	25.5	25.5	18.3	18.3	25.5	18.3	18.3	25.5	18.3	25.5	18.3
Max. temperature material	°C	55													80		55	
	°F	131													176		131	
Max. temperature air	°C	43																
	°F	109																
Sound level at 0.3 MPa; 3 bar; 43.5 psi air pressure and 11 MPa; 110 bar; 1549 psi material pressure***	dB(A)	76.0						76.5						76.0		76.5		

* According to nozzle, see chapter 9.1.

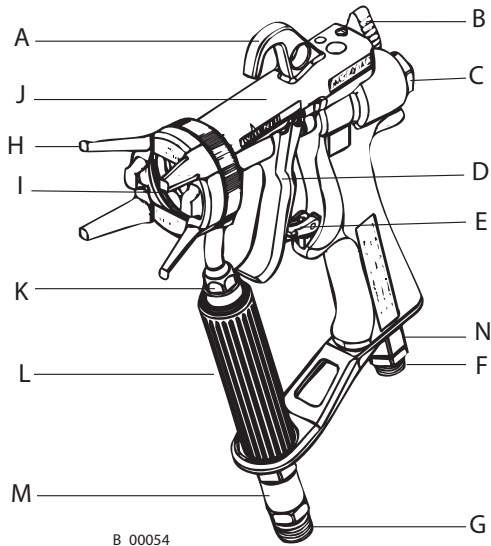
** Filter types see paragr. 9.6

*** A rated sound pressure level measured in 0.5m distance according to DIN EN ISO 3746-1995



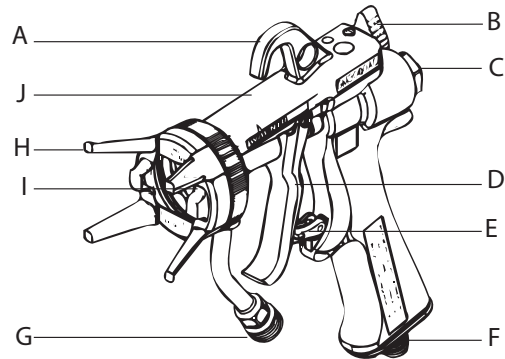
4.4 FUNCTIONAL DESCRIPTION

4.4.1 DESIGN OF SPRAYGUN



B_00054

GM 3000AC with filter



B_00056

GM 3000AC without filter

	Description		Description
A	Suspension hook	H	Aircap nut and nozzle guard
B	Shaping air control knob	I	Nozzle / air cap
C	Tension cap	J	Spraygun body
D	Trigger	K	Filter housing
E	Safety catch	L	Tube handle
F	Air connector	M	Pivot joint, material
G	Material connector	N	Pivot joint, air

4.4.2 OPERATION OF THE SPRAYGUN

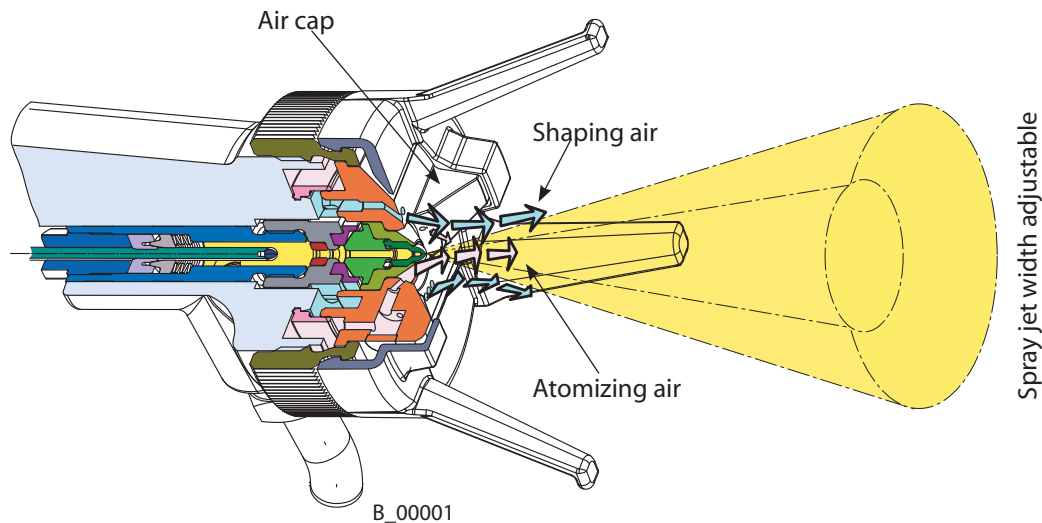
Pulling the trigger (D) approximately 1/2 way opens the air valve allowing atomising and shaping-air to flow through the aircap. When the trigger is pulled further, more resistance is felt and the material valve is opened. The atomising air control adjusts the total quantity of air flowing through the spray gun.

The spray gun is rendered safe with the trigger safety catch (E). (Turn the trigger safety catch in the spraying direction and fasten in the groove)

4.5 JET PROCESS

4.5.1 AIRCOAT FLAT JET PROCESS

With the AirCoat process the spray material is atomized at a pressure of 3-12 MPa; 30-120 bar; 435-1740 psi. A soft, flat spray is achieved with help of the AirCoat air, which has a pressure of 0.05-0.25 MPa; 0.5-2.5 bar; 7.2-36 psi. The shaping air (C) provides the potential to make the width of the spray jet larger and smaller.



Advantages

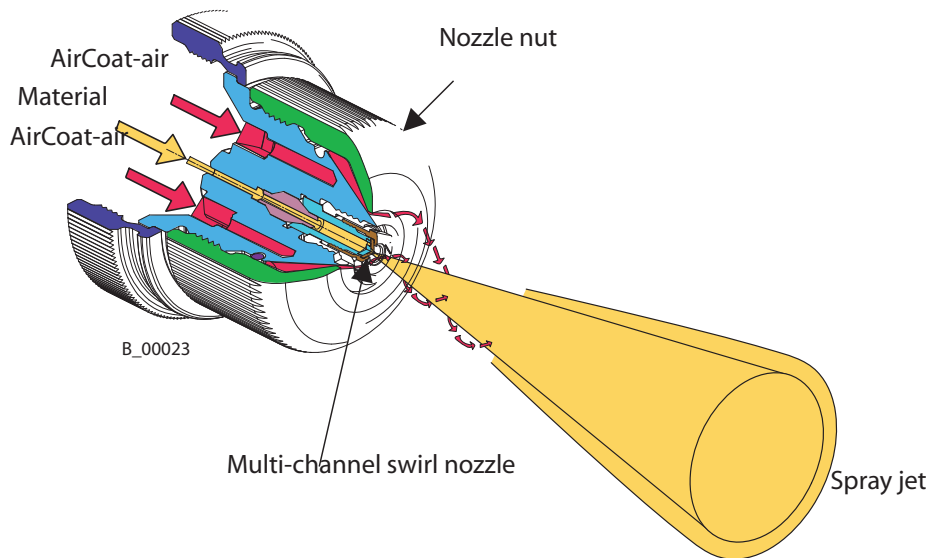
- High painting capacity
- Low mist formation
- Good finish
- High-solids paints can easily be applied
- Adjustable spray fan.

4.5.2 AIRCOAT ROUND JET PROCESS

In the AirCoat process, high pressure of 3-12 MPa; 30-120 bar; 435-1740 psi is used to atomize the material.

The AirCoat air at 0.05-0.25 MPa; 0.5-2.5 bar; 7.2-36 psi produces a soft jet, which largely eliminates the problem of overlapping boundaries.

The spray jet can be adjusted by turning the nozzle nut. The multi-channel swirl nozzle produces fine paint particles, while at the same time reducing their forwards speed and swirling them to produce a rotating motion. The result is a soft, extremely well atomized spraying cloud.





Advantages

- High painting capacity
- Low fogging tendency
- Good finish
- High- viscosity paints can easily be applied

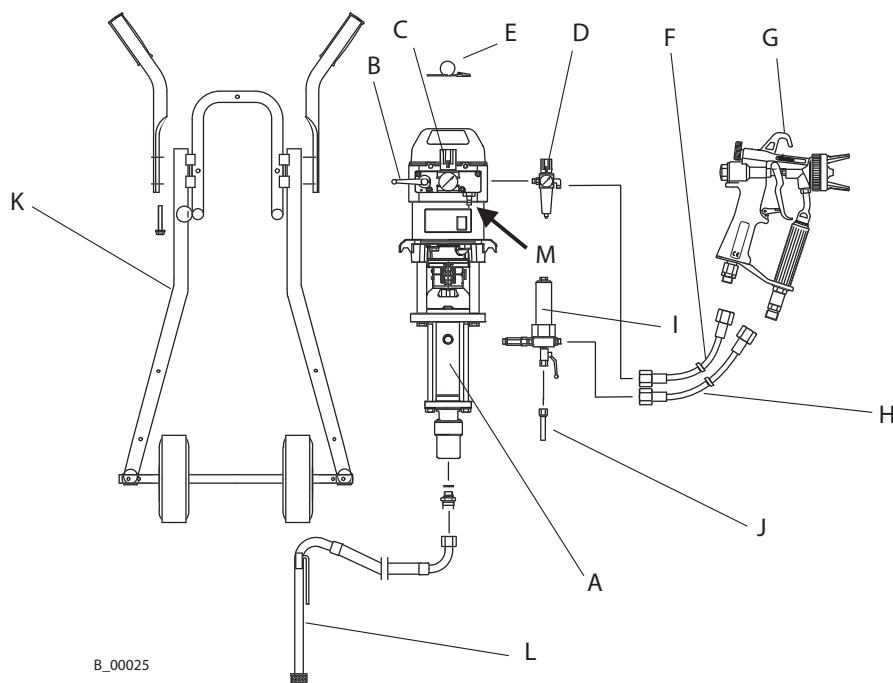
5 PREPARATION BEFORE STARTING WORK

5.1 SET UP AND CONNECT

5.1.1 TYPICAL AIRCOAT INSTALLATION

	 WARNING
	<p>Incorrect installation/operation! Risk of injury and damage to equipment</p> <p>→ When putting into operation and for all work, read and follow the operating instructions and safety regulations for the additionally required system components.</p>

SIHI_0050_GB





B_00025

- A Paint-pump
- B Air shut-off valve
- C Air regulator
- D Air regulator with filter
- E Earthing cable
- F Air hose (electrically conductive)
- G AirCoat spray gun
- H HP-fluid hose
- I HP-filter/ relief valve
- J Relief tube
- K Stand Trolley
- L Suction system
- M Mains air inlet

The spray gun GM 3000AC must be used a part of an AirCoat spraying system. The AirCoat system shown in the figure is only one example of an AirCoat spraying system. Contact your WAGNER distributor for assistance in designing a system to meet your needs. The operating instructions and the safety regulations for the additional system components used must be read before starting-up

5.1.2 VENTILATION OF THE SPRAY BOOTH

	 WARNING
	<p>Toxic and/or flammable vapor mixtures! Risk of poisoning and burns</p> <ul style="list-style-type: none"> → Operate the unit in a spraying booth approved for the working materials. -or- → Operate the unit on an appropriate spraying wall with the ventilation (extraction) switched on. → Observe national and local regulations for the outgoing air speed.

SIHI_0028_GB



5.1.3 AIR SUPPLY

The use of an air filter with the air regulator (D) ensures that only dry, clean atomising air gets into the spray gun. Dirt and moisture in the atomising air reduce the spraying quality and the appearance of the finished piece.

5.1.4 FLUID (PAINT) HOSES



CAUTION
<p>Impurities in the spraying system! Spray gun blockage, materials harden in the spraying system.</p> <p>→ Flush the spray gun and paint supply with a suitable cleaning agent.</p>

SIHI_0001_GB



	 DANGER
	<p>Bursting hose, bursting threaded joints! Danger to life from injection of material</p> <ul style="list-style-type: none"> → Ensure that the hose material is chemically resistant. → Ensure that the spray gun, threaded joints and material hose between the unit and the spray gun is suitable for the pressure generated in the unit. → Ensure that the following information can be seen on the high-pressure hose: <ul style="list-style-type: none"> - Manufacturer - Permissible operating pressure - Date of manufacture.

SIHI_0029_GB

5.1.5 EARTHING

	 WARNING
	<p>Discharge of electrostatically charged components in atmospheres containing solvents! Explosion hazard from electrostatic sparks or flames.</p> <p>→ Earth all unit components. → Earth the workpieces being painted.</p>

SIHI_0027_GB

	 WARNING
	<p>Heavy paint mist if earthing is insufficient! Risk of poisoning Insufficient paint application quality</p> <p>→ Earth all unit components. → Earth the workpieces being painted.</p>

SIHI_0003_GB

Any material containers and the unit must be connected by a potential equalisation (earth) cable.

5.2 PREPARATION OF PAINTS

The viscosity of the paint is of great importance. The best results are obtained for paints of 80 and 150 milli Pascal x Sec (mPas).



In most cases, the application of paints of up to 260 mPas for high film-thicknesses does not cause any problems.

5.2.1 VISCOSITY CONVERSION TABLE

milli Pascal x Sec mPas	Centipoise	Poise	DIN Cup 4 mm ; 0.16 in	Ford Cup 4	Zahn 2
10	10	0.1		5	16
15	15	0.15		8	17
20	20	0.2		10	18
25	25	0.25	14	12	19
30	30	0.3	15	14	20
40	40	0.4	17	18	22
50	50	0.5	19	22	24
60	60	0.6	21	26	27
70	70	0.7	23	28	30
80	80	0.8	25	31	34
90	90	0.9	28	32	37
100	100	1	30	34	41
120	120	1.2	33	41	49
140	140	1.4	37	45	58
160	160	1.6	43	50	66
180	180	1.8	46	54	74
200	200	2	49	58	82
220	220	2.2	52	62	
240	240	2.4	56	65	
260	260	2.6	62	68	
280	280	2.8	65	70	
300	300	3	70	74	
320	320	3.2			
340	340	3.4			
360	360	3.6	80		
380	380	3.8			
400	400	4	90		

5.3 START-UP**5.3.1 GENERAL RULES FOR MAKING ADJUSTMENTS TO THE SPRAY GUN**

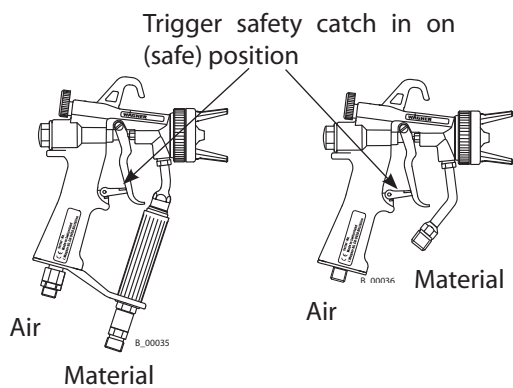
→ See **safety regulations** in chapter 2.

	 WARNING
	<p>Unintentional putting into operation! Risk of injury</p> <p>Before all work on the unit, in the event of work interruptions and functional faults:</p> <ul style="list-style-type: none"> → Switch off the energy/compressed air supply. → Relieve the pressure from the spray gun and unit. → Secure the spray gun against actuation. → By functional faults: Identify and correct the problem, proceed as described in chap. „Trouble shooting“.

SIHI_0065_GB

<h2>CAUTION</h2>
<p>Cleaning agent in the air duct! Functional faults caused by swollen seals</p> <ul style="list-style-type: none"> → Always point the spray gun down when cleaning. → Ensure that neither paint nor cleaning agent enters the air duct.

SIHI_0005_GB

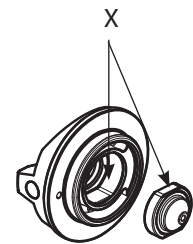


5.3.2 PREPARATION

1. Secure the spraygun.
2. Connect material hose to spray gun and to pump.
3. Connect air hose to spray gun and to oil-free, dry air supply with regulator.
4. Insert suitable gun filter.
5. Tighten the complete gun handle/ swivel assembly.
6. Place the nozzle into the nozzle seal. Fit the aircap over the nozzle, ensuring that the location flats (X) are in line. Fit the aircap nut with nozzle guard and tighten by hand.

Note:

The pin in the housing is to adjust the spray jet in the horizontal or vertical position.



B_00044

7. Visually check the permissible pressures for all the system components.
8. Make sure that the spraying unit and all other conductive parts within the work area are earthed
9. Set material pressure approx. 100 bar; 10 MPa; 1450 psi and use a suitable medium (solvent or water) to check that connections do not leak.

Note:

Pull the trigger and then release, checking that the gun closes cleanly.

10. Relieve spray gun and unit pressure and secure the spraygun.

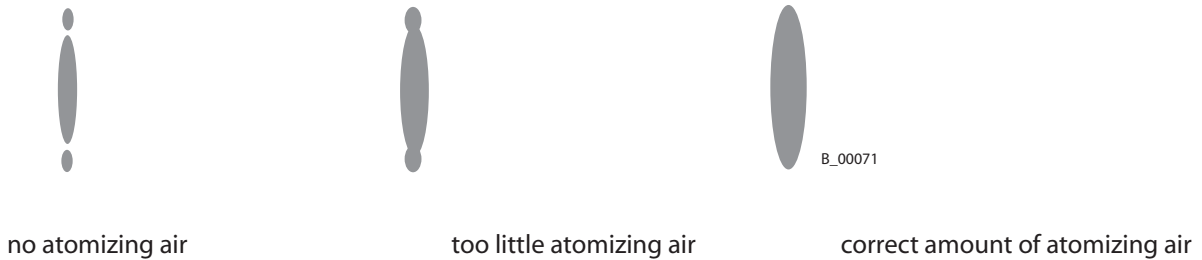
5.4 WORKING

5.4.1 START-UP AIRCOAT SPRAYING

1. Set material pressure to approx. 8MPa; 80 bar; 1160 psi at material pump.
2. Spray (release trigger safety catch and pull trigger) and check the atomisation.
3. Set the fluid pressure to the point where a further increase in fluid pressure would significantly improve fluid atomization.
4. Now open AirCoat-air on the atomizing air regulator and set.
5. Adjust the pressure to get the optimum spraying finish. Relation between spray pattern and atomizing air see illustration. Set the minimum air pressure necessary to achieve the best possible spray pattern.

Note:

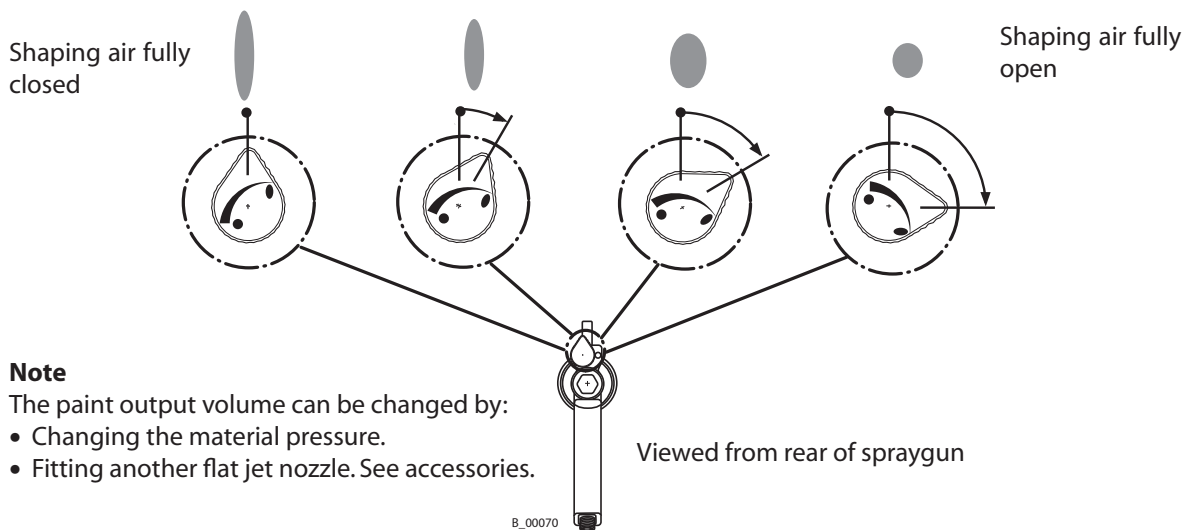
Repeat point 4 and 5 until the optimum spray pattern is reached

Spray patterns

5.4.2 ADJUSTING THE SPRAY PATTERN

The spray pattern can be adjusted to suit the object being sprayed using the shaping air regulator. The illustration below shows the influence of the shaping air regulator on the spraying pattern.

Other tip sizes can be used to obtain larger or smaller spraying patterns.

**Note**

The paint output volume can be changed by:

- Changing the material pressure.
- Fitting another flat jet nozzle. See accessories.

5.4.3 CHANGING AIRCOAT NOZZLE**CAUTION****Defective AirCoat nozzle!**

Insufficient paint application quality

→ Do not use sharp-edged objects to treat hard metal on the AirCoat nozzle.

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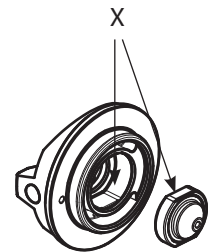
CAUTION**Defective nozzle seal!**

Material sprays into the air cap next to the nozzle
Risk of contamination

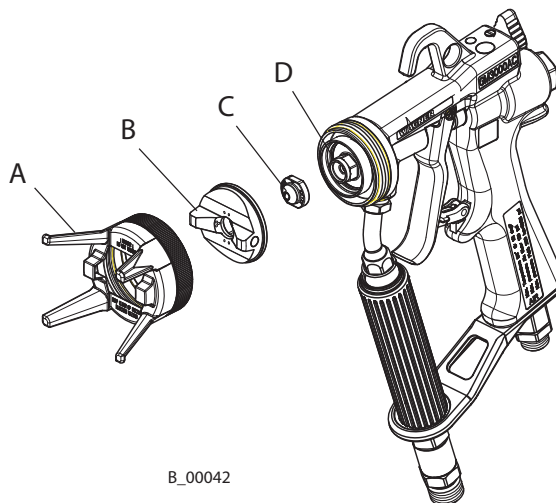
→ Do not clean the nozzle seal with sharp-edged objects.
→ Replace the nozzle seal if the sealing surface is damaged.

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1. Relieve the pressure from the gun and unit.
2. Secure gun with trigger safety catch.
3. Unscrew aircap nut (A)
4. Remove air cap (B) and nozzle (C).
5. Press AirCoat nozzle (C) out of the air cap by hand and brush with cleaning solvent until all remaining paint has been dissolved.
6. **Assembly:**
Place AirCoat nozzle (C) in nozzle seal (D).
7. Place air cap (B) on the nozzle (C). Take care that the nozzle fitted is correctly (see flats X)
8. Fit the aircap nut with nozzle guard (A) over the air cap (B) onto the spray gun and tighten by hand.



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B_00042

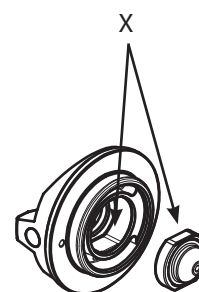
5.4.4 CLEANING AIRCOAT NOZZLES

For disassembly and assembly see AirCoat nozzles section 5.4.3.

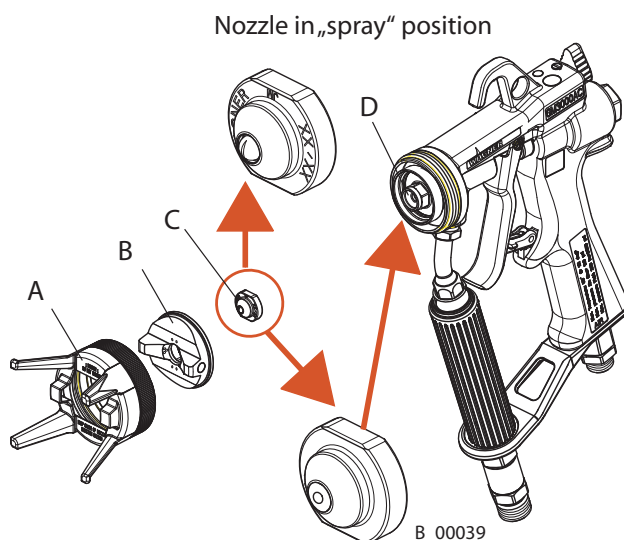
The AirCoat nozzle (C) can be placed into a cleaning solvent which has been recommended by the paint manufacturer.

5.4.5 UNBLOCKING CLOGGED NOZZLE

1. Relieve the pressure from the gun and unit.
2. Secure gun with trigger safety catch.
3. Unscrew aircap nut with nozzle guard (A).
4. Remove aircap (B).
5. Pull out the clogged nozzle (C) from the air cap (B), reverse it and replace it into nozzle seal (D).
6. Place air cap (B) on the nozzle (C). Take care that the nozzle fitted is correctly (see flats X)
7. Fit the aircap nut with nozzle guard (A) over the air cap (B) onto the spray gun and tighten by hand.
8. Switch the material pressure back on.
9. Turn the safety catch to the spraying position and briefly pull trigger.
10. When the blockage has been flushed out secure the gun with safety catch.
11. Relieve the pressure from the gun and unit.
12. Unscrew aircap nut with nozzle guard (A).
13. Remove air cap (B) and reverse nozzle (C) again.
14. Refit air cap (B) on the nozzle (C). Take care that the nozzle fitted is correctly (see flat side X)
15. Fit the aircap nut with nozzle guard (A) over the air cap (B) onto the spray gun and tighten by hand.
16. Switch the material pressure and the air pressure back on.



B_00044



B_00039

Nozzle in „cleaning“ position

6 MAINTENANCE

→ See **safety regulations** in chapter 2.

The spray gun and the unit must be cleaned every day. Use only the cleaning solvent recommended by the material manufacture.

CAUTION

Cleaning agent in the air duct!

Functional faults caused by swollen seals

→ Never immerse the spray gun in cleaning agent.

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WARNING



Incorrect maintenance/repair!

Risk of injury and damage to the equipment

- Repairs and part replacement may only be carried out by specially trained staff or a WAGNER service center.
- Before all work on the unit and in the event of work interruptions:
 - Switch off the energy/compressed air supply.
 - Relieve the pressure from the spray gun and unit.
 - Secure the spray gun against actuation.
- Observe the operating and service instructions when carrying out all work.

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6.1 FINISHING WORK AND CLEANING

	 DANGER
	<p>Exploding gas/ air mixture! Danger to life from flying parts and burns</p> <p>→ Never spray into a closed container. → Earth the container.</p>

SIHI_0008_GB

<h2>CAUTION</h2>
<p>Cleaning agent in the air duct! Functional faults caused by swollen seals</p> <p>→ Always point the spray gun down when cleaning. → Ensure that neither paint nor cleaning agent enters the air duct.</p>

SIHI_0005_GB

	 WARNING
	<p>Explosive atmosphere! Explosive gases are produced when aluminium comes into contact with halogenized hydrocarbons.</p> <p>→ To clean aluminium, do not use liquids containing halogenized hydrocarbons.</p>

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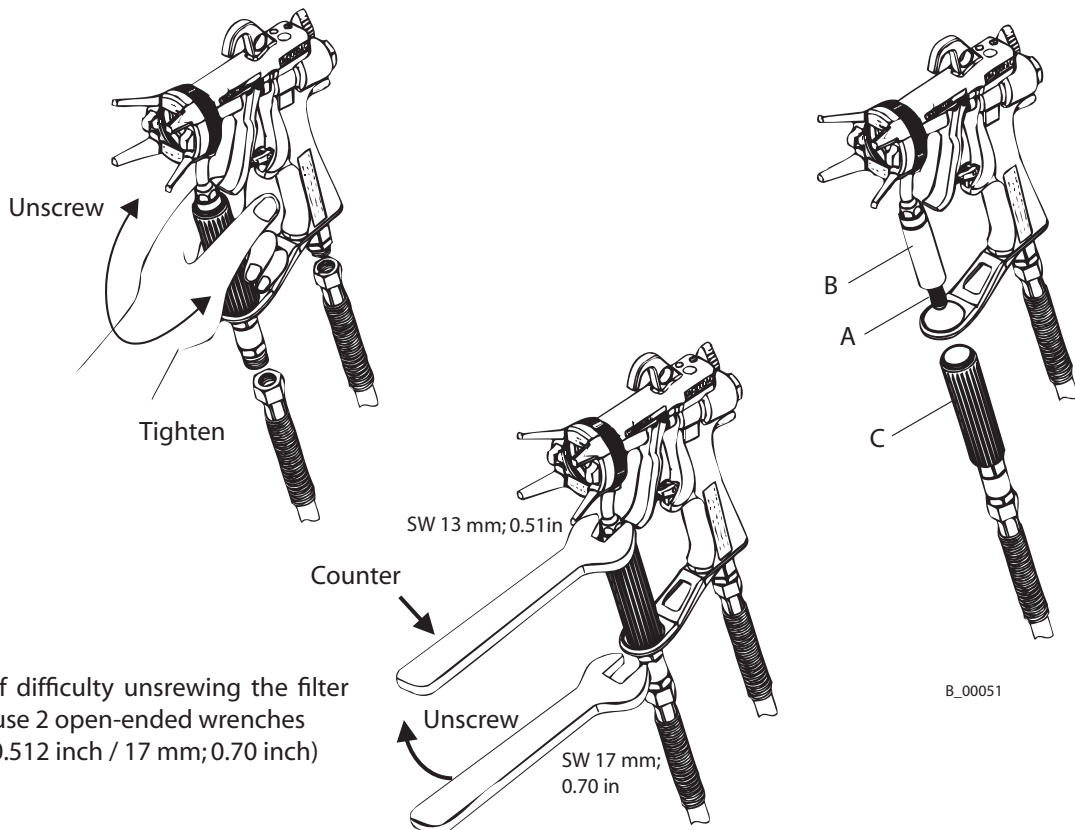
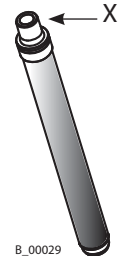
Note:

Methylene chloride is not recommended as a flushing or cleaning solvent with this gun or any system components.

1. Relieve the pressure from the gun and unit.
2. Secure gun with trigger safety catch.
3. Replace material with cleaning agent.
4. Remove and clean the AirCoat nozzle. (see section 5.4.3)
5. Pressurize the cleaning supply to approx. 4 MPa; 40 bar; 580 psi max. and thoroughly flush the spray gun.
6. Relieve spray gun and unit pressure!
7. Secure gun with trigger safety catch.
8. Clean gun body with a cleaning agent recommended by the manufacturer, and dry with a cloth.

6.2 CHANGING OR CLEANING FILTER

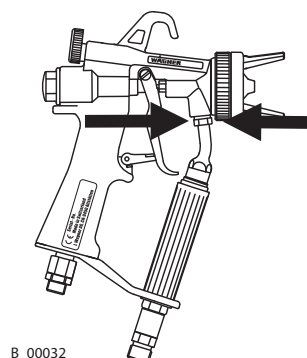
1. Take spraygun out of operation and clean.
2. Relieve the pressure from the gun and unit.
3. Secure gun with trigger safety catch.
4. Unscrew the complete swivel assembly with the filter housing, and remove downwards with the hose.
5. Remove the filter insert (A) from the filter housing (B).
6. Clean the swivel, filter housing and filter (A) with cleaning agent.
7. Fit the cleaned or new filter insert (A) into the filter housing with the conical end (X) pointing upwards.
8. Push the filter housing over the swivel hexagon, then slide the whole assembly over the gun filter and tighten by hand.

**Note:**

In case of difficulty unscrewing the filter housing use 2 open-ended wrenches (13 mm; 0.512 inch / 17 mm; 0.70 inch)

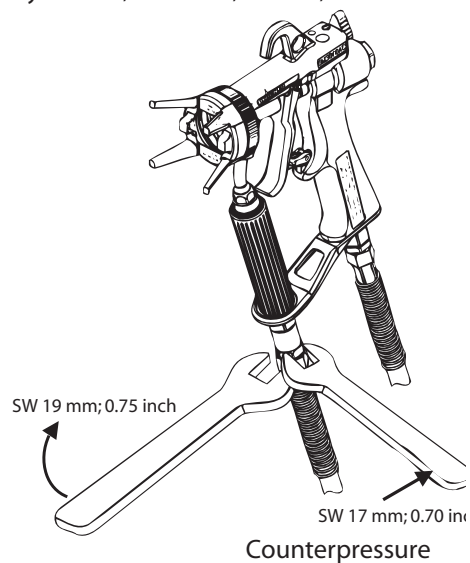
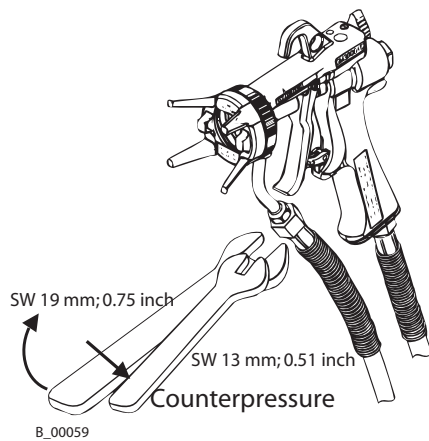
Note:

Do not unscrew the paint connection. The nut must only be unscrewed by WAGNER- Service-Agency.

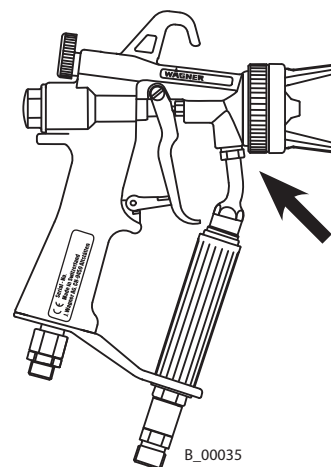
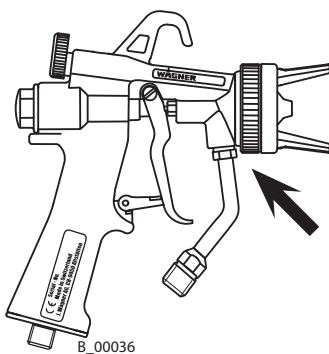


6.3 CHANGING MATERIAL HOSE

1. Put out of operation and clean.
2. Relieve the pressure from the gun and unit.
3. Secure gun with trigger safety catch.
4. Place open-ended wrench 13 mm; 0.51 inch respectively 17 mm; 0.70 inch on flats of paint connection respectively swivel and counterhold.
5. Turn nut to the right with open-ended wrench 19 mm; 0.75 inch and unscrew material hose.
6. **Assembly:**
Fit the material hose by hand and tighten with 2 open-ended wrenches
13 mm; 0.51 inch; 19 mm; 0.75 inch respectively 17 mm; 0.70 inch; 19 mm; 0.75 inch

**Note:**

Do not unscrew the paint connection. The nut must only be unscrewed by WAGNER- Service-Agency.



6.4 REPLACING PARTS OF THE VALVE STEM

6.4.1 DISMANTLING

1. Take spraygun out of operation and clean.
2. Relieve the pressure from the gun and unit.
3. Secure gun with trigger safety catch.
4. Unscrew the tension cap (A) remove the springs (B) and (C).
5. Remove trigger pin (H) and screw (J).
6. Remove the trigger (I).
7. Loosen packing screw (G) with open-ended wrench 7 mm; 0.275 inch .
8. Push the valve tappet (E) together with the valve rod (D) backwards by hand.
9. Using pliers pull out parts (E) and (D).

CAUTION

Unsuitable tool!

Damage to seals and sealing surfaces

→ Do not hold the valve rod with pliers or a similar tool.

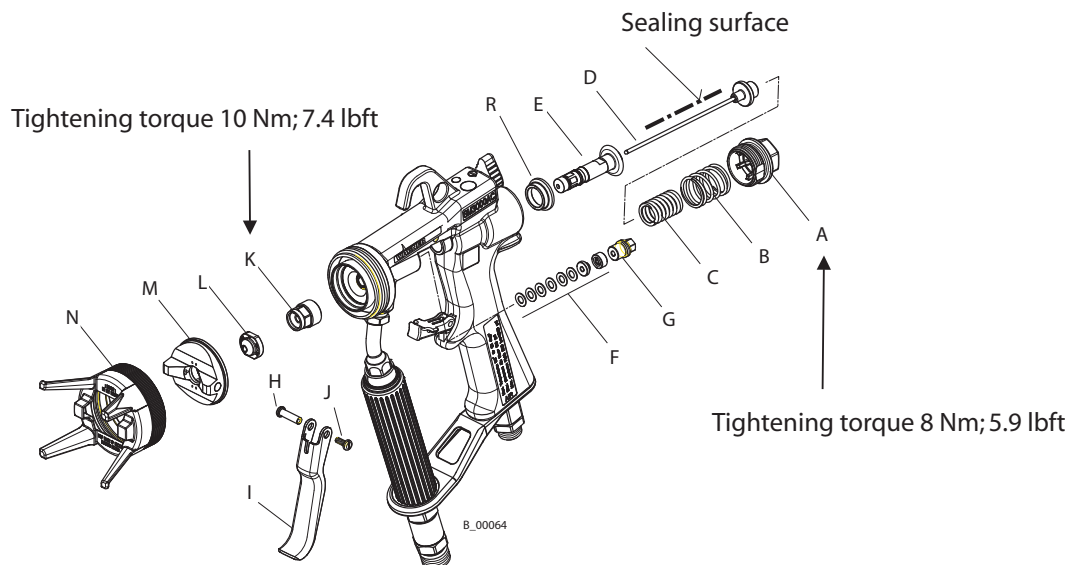
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10. Remove packing screw (G) with open-ended wrench 7 mm; 0.275 inch.
11. Remove sealing package (F).

Note:

If parts remain stuck in the hole then remove the air cap (M) with the nozzle (L), then the valve seat holder (K) using a 12 mm; 0.472 inch wrench and remove. The stuck components can then be pushed out with a drift max. \varnothing 4.5 mm; 0.177 inch.

12. Exchange any worn parts.

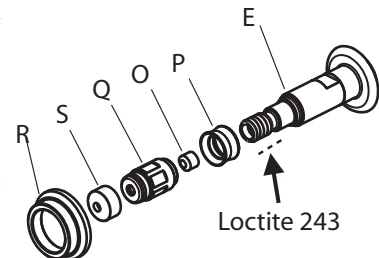


6.4.2 REPLACING SEALS IN THE VALVE TAPPET

1. Heat valve tappet assy. to about 150°C; 302°F.
2. Place a 7 mm; 0.28 inch wrench on the valve tappet (E) and hold. Unscrew the tappet cap (Q) with an 8 mm; 0.31 inch wrench.
3. Remove and replace tappet seal (O) and seal (P).

Note:

The seal (O) can be unscrewed from the valve tappet (E) using a small screwdriver pushed into it

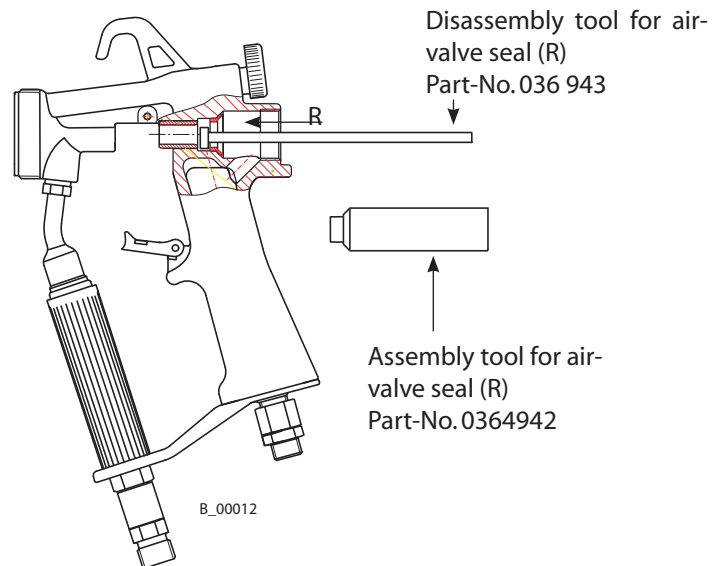


When the air-valve leaks:

4. Remove the air-valve seal (R) from the gun-housing and replace. Clean sealing surfaces in the gun housing.

When the slide cap (S) is damaged:

5. Cut the slide cap (S) with a shrap knife and press a new one onto the tappet cap.

**6.4.3 REASSEMBLING**

1. Screw in the valve seat (K) and tighten using a 12 mm; 0.472 inch torque wrench to a torque of 10 Nm; 7.4 lbft.
2. See section 5.4.3 for reassembly of air-cap.
3. Lightly grease the tappet seal (O) and the seal (P) and assemble on valve tappet (E).
4. Push in valve stem (D).

Note:

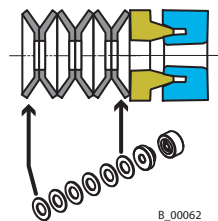
Only silicon-free or resin-free grease is permitted to be used.

5. Screw the air valve tappet (E) and tappet cap (Q) together using loctite 243 by hand. Carefully tighten using 7 mm; 0.275 inch / 8 mm; 0.314 inch wrenches until slight resistance is felt when sliding the valve stem in and out.
6. Place the seal package (F) on the valve rod (D) and insert into the hole in the housing from the rear.

7. Pull the valve rod (D) out again.
8. Screw in the packing screw (G) and **do not tighten fully**.
9. Put trigger (I) in position, and insert trigger pin (H) and screw (J).
10. Place the valve tappet (E) over the valve rod (D). Push both parts from behind into the housing.
11. Place the springs (C) and (B) in place and tighten tension cap (A) to a torque of 8 Nm; 5.9 lbft.
12. Tighten seal package (F) with packing screw (G) carefully. Take care of a smooth movement of trigger.
13. Start-up see chapter 5.3.

Note:

Ensure that the springs plates in the sealing package (F) are in the correct position.



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6.5 REPLACING NOZZLE SEAL**CAUTION****Forming air and atomizer air not separate !**

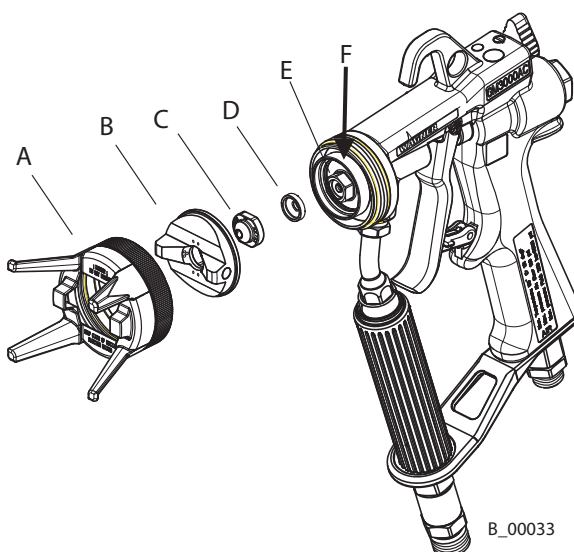
Poor spray pattern

Spray jet cannot be adjusted

→ Treat the distributor seal (F) with care.

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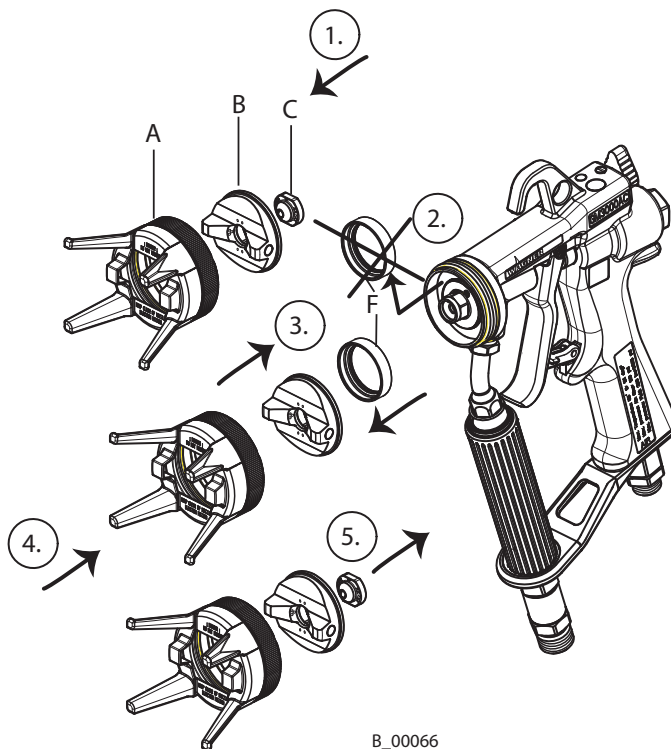
1. Take out of operation and clean.
2. Relieve the pressure from the gun and unit.
3. Secure gun with trigger safety catch.
4. Unscrew aircap nut with nozzle guard (A)
5. Remove air cap (B) and nozzle (C).
6. Prise the tip seal (D) out using a small screwdriver.
7. Push the new nozzle seal into the valve seat holder (E).
8. Re-assemble aircap in reverse order



B_00033

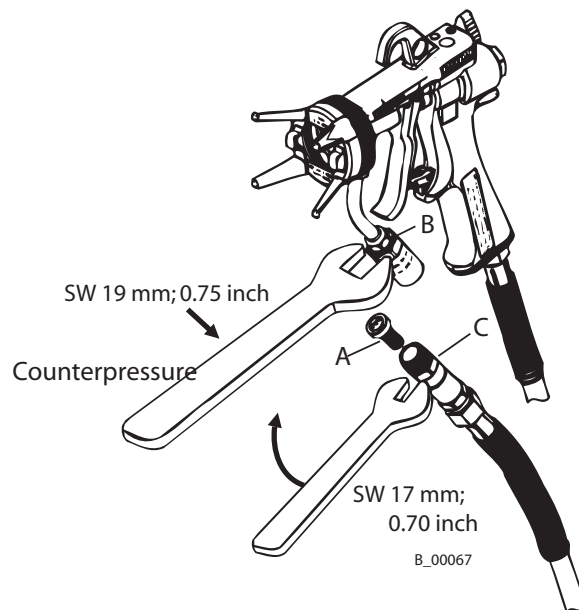
6.6 REPLACING SEAL (DISTRIBUTOR)

1. Take out of operation and clean.
2. Relieve the pressure from the gun and unit.
3. Secure gun with trigger safety catch.
4. Unscrew aircap nut with nozzle guard (A)
5. Remove air cap (B) and nozzle (C).
6. Pull the damaged seal (F) out using a pliers
7. **Assembly:** Put the new seal (F) on the air cap (B).
8. Place the air cap and seal into gun housing.
9. Set aircap nut (A) and screw in as far as the seal ring (F) in the groove catches. (snap hearable)
10. Disassemble aircap nut and aircap an complete the spray gun. See chapter 5.4.3.



6.7 CHANGING OR CLEANING EDGE FILTER (OPTIONAL)

1. Put out of operation and clean.
2. Relieve the pressure from the gun and unit.
3. Secure gun with trigger safety catch.
4. Place open-ended wrench 19 mm; 0.75 inch respectively 17 mm; 0.70 inch on flats of filter housing (B) respectively swivel (C) and counterhold.
5. Turn nut to the right with open-ended wrench 17 mm; 0.70 inch and unscrew pivot joint (C) with material hose.
6. Remove edge filter (A)
7. Clean the filter housing (B) respectively swivel (C) and edge filter (A) with cleaning agent.
8. **Assembly:**
Fit the cleaned or new edge filter into the pivot joint (C).
9. Fit pivot joint with the material hose by hand and tighten with 2 open-ended wrenches 17 mm; 0.70 inch / 19 mm; 0.748 inch.



7 TROUBLE SHOOTING AND SOLUTIONS

Problem	Cause	Solution
Paint output too low	Nozzle too small	Select larger nozzle (see para. 9.1)
	Paint pressure too low	Adjust at pump as required.
	Gun filter blocked or HP filter at pump clogged	Clean/ replace filters (see para. 6.1)
	Nozzle blocked or	Clean nozzle (see section 5.4.5)
	Trigger/ valve stem defective	Replace valve stem
Poor quality spray pattern	Incorrect atomizing air pressure	Re-adjust (see para. 5.4.1)
	Nozzle too large	Select smaller nozzle (see para. 9.1)
	Paint pressure too low	Increase pressure at pump
	Material viscosity too high	Thin material acc. to manufacturer's instruction.
	Partial nozzle blockage	Clean nozzle (see para. 5.4.5)
	Incorrect fanair adjustment (fan too wide or too narrow)	Re-adjust fanair control on spraygun (see para. 5.4.1)
	Aircap faulty (blocked holes, damaged seal)	Clean or replace aircap
	Wrong aircap type	Replace as required (solvent / waterbased)
Leaking valve stem seals (paint or air)	Paint seal (packing) amaged or worn, valve stem damaged.	Adjust or replace packing or replace valve stem cpl.
	Air valve seals damaged.	Replace air valve seals (see para. 6.3)
	Pretension too low	Tighten the sealing screw
Spaygun will not shut-off correctly	Worn valveseat / valve ball	Replace as required
	Packing-screw too tight, or packing stuck with dried paint	Retension or replace packing

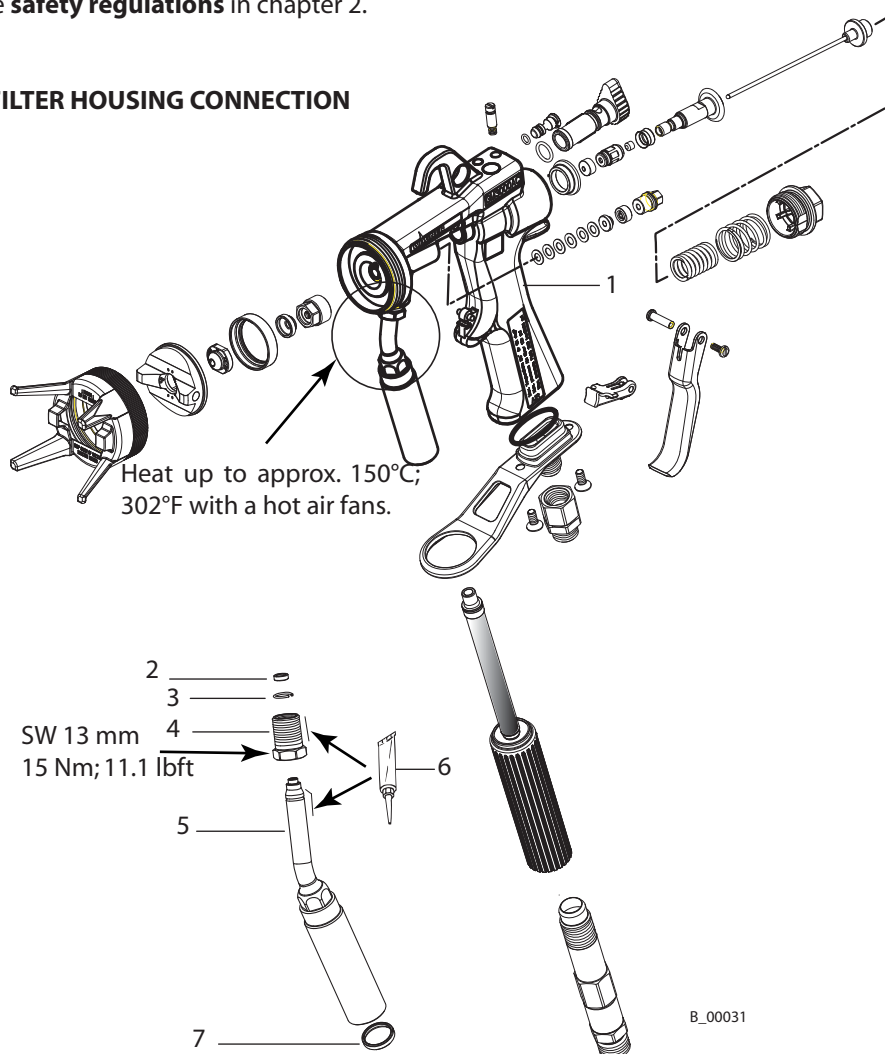
8 REPAIR WORK

	WARNING
	<p>Incorrect maintenance/repair! Risk of injury and damage to the equipment</p> <ul style="list-style-type: none"> → Repairs and part replacement may only be carried out by specially trained staff or a WAGNER service center. → Before all work on the unit and in the event of work interruptions: <ul style="list-style-type: none"> - Switch off the energy/compressed air supply. - Relieve the pressure from the spray gun and unit. - Secure the spray gun against actuation. → Observe the operating and service instructions when carrying out all work.

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→ See **safety regulations** in chapter 2.

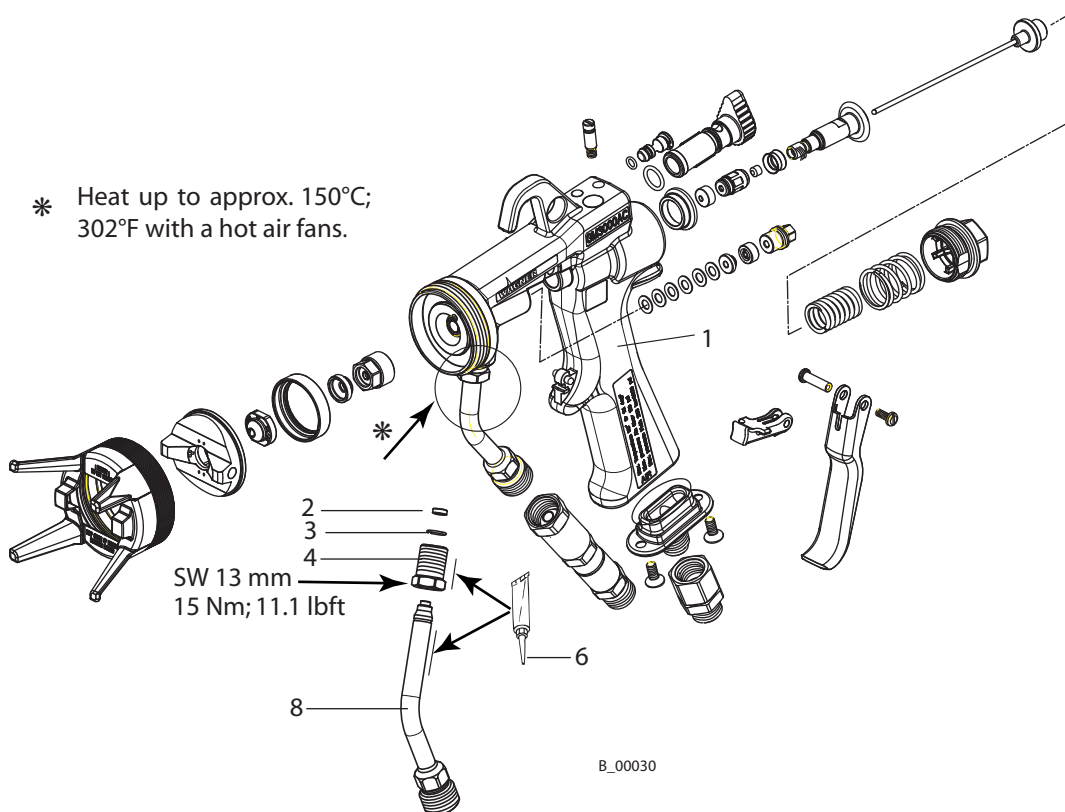
8.1 FILTER HOUSING CONNECTION



B_00031

Disassembly

1. Remove all moving parts of the spray-gun
2. Heat up to approx. 150°C; 302°F the area of the banjo bolt (4).
3. Unscrew banjo bolt (4) with open-end wrench (size 13 mm; 0.51 inch) and remove filter housing (5) with seal material (7) or material outlet fitting (8).
4. Clean all reusable parts using a suitable solvent.





Repair spare parts

Item	K	Qty	Part-No.	Description
1		1	0364927	Gun housing pre-assembled filter
1		1	0364928	Gun housing pre-assy. M16x1.5
1		1	0364929	Gun housing pre-assy. NPSM1/4"
1		1	0364934	Gun housing AC-H M16x1.5
2		1	0364339	Seal material inlet
3		1	9922720	Snap ring
4		1	0364336	Banjo bolt
5		1	0364343	Filter housing bended
6		1	9992833	Loctite 638 green
7		1	0364340	Seal filter
8		1	0364353	Material outlet fitting M16x1.5
8		1	0364355	Material outlet fitting NPSM1/4"
9		1	9992528	Loctite 270

Assembly

1. Push the new banjo bolt (4) onto filter housing (5) or onto material outlet nipple (8).
2. Place the snap ring (3) in the groove of filter housing (5) and place the seal material (2) onto filter housing (5).
3. Apply loctite 638 to the thread of the bajo bolt (4) and of the filter pipe (5).
4. Push complete filter housing or material outlet fitting onto gun housing and ensure that it is in the correct position. Tighten the banjo bolt (4) using a torque wrench to a torque of 15 Nm; 11 lbft.
5. Put the cemented joint for 30 minutes at 40°C; 104°F in a oven.
6. Assemble the spraygun and check the gun for leaks using solvent or spray oil and a max. pressure of 25 MPa; 250 bar; 3626 psi or 16 MPa; 160 bar; 2320 psi.
7. Check the gun for leaks using solvent or spray oil and a max. pressure of 25 MPa; 250 bar; 3626 psi or 16 MPa; 160 bar; 2320 psi

8.2 PIVOT JOINT PAINT

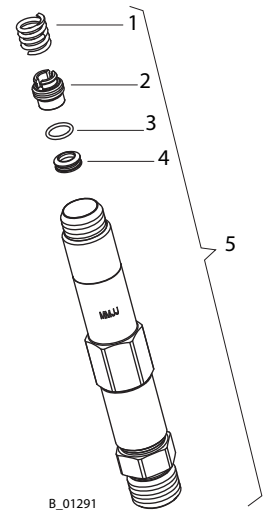
	 WARNING
	<p>Defective parts! Leakage caused by defective parts. The resulting spray jet can inject material into the body (skin, eyes etc.) .</p> <p>→ Always replace defective parts, O-rings and seal sets. → Ensure that adhesion points are clean and free of grease.</p>

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Disassembly

1. Remove pressure spring (1) and unscrew adjuster screw (2).
2. Remove o-ring (3) and gasket (4).

Item	K	Qty	Part-No.	Description
1		1	0043590	Pressure spring
2		1	0364374	Adjuster screw
3		1	9971147	O-ring
4		1	0364375	Gasket
5		1	0364923	Pivot joint paint M16x1,5
5		1	0364924	Pivot joint paint NPSM1/4"-18
6		1	9992528	Loctite 270
7		1	9992695	Castor oil



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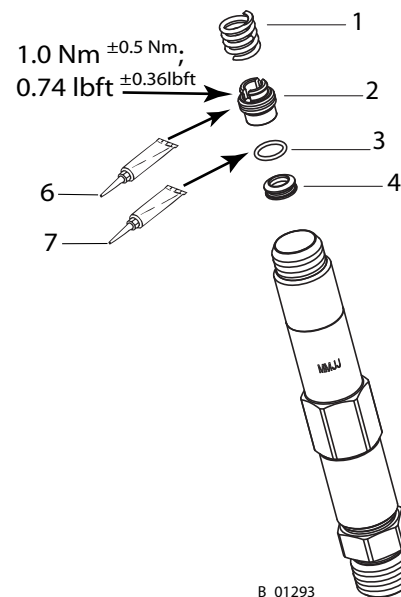
Assembly

1. Lightly grease o-ring (3) using castor oil and push it onto gasket (4). Insert the gasket assy. into connection piece.

Note
By assembling do not damage gasket (4).
2. Screw adjuster screw (2) into connection piece using Loctite 270.

Note
Do not thighten fully the adjuster screw.
3. Tighten the adjuster screw (2) using a torque wrench to a torque of $1.5 \text{ Nm} \pm 0.5 \text{ Nm}$; $1.84 \text{ lbft} \pm 0.37 \text{ lbft}$.
4. Push the pressure spring (1) onto the adjuster screw (2).
5. Put the assembled part for 30 minutes at 40°C ; 104°F in a oven.

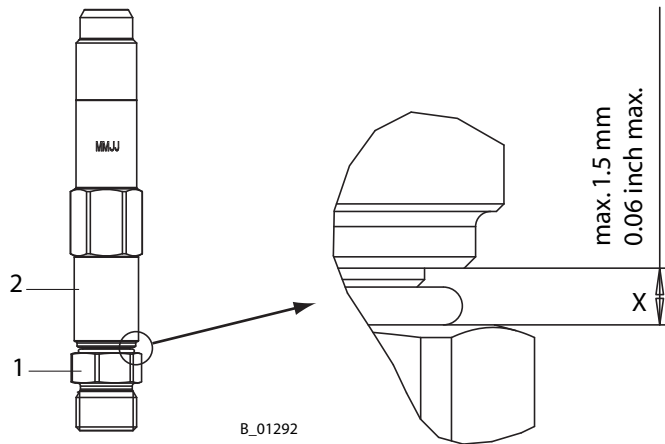
Note
The part must be placed in the oven on the connection piece.
(Pressure spring downstairs)
6. Check the pivot joint for leaks using solvent or spray oil and a max. pressure of 25 MPa; 250 bar; 3626 psi or 16 MPa; 160 bar; 2320 psi.





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Dimensional accuracy:

If the distance „x“ between pinhead (1) and distance piece (2) is larger than 1.5 mm; 0.06 inches, the pivot joint must be replaced.



8.3 PIVOT JOINT PAINT LW

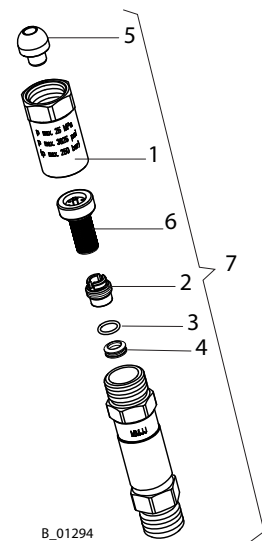
	 WARNING
	<p>Defective parts! Leakage caused by defective parts. The resulting spray jet can inject material into the body (skin, eyes etc.) .</p> <p>→ Always replace defective parts, O-rings and seal sets. → Ensure that adhesion points are clean and free of grease.</p>

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Disassembly

1. Unscrew the filter housing (1) from the connection piece and remove the edge filter (6) and nipple (5).
2. Unscrew adjuster screw (2). Remove o-ring (3) and gasket (4).

Item	K	Qty	Part-No.	Description
1		1	0364379	Filter housing M16x1.5 LW
1		1	0364380	Filter housing NPS1/4"-18 LW
2		1	0364374	Adjuster screw
3		1	9971147	O-ring
4		1	0364375	Gasket
5		1	0179456	Nipple for M16x1.5
5		1	0179457	Nipple for NPS1/4"-18
6		1	3204605	Edge filter 100 meshes
7		1	0364925	Pivot joint paint LW M16x1.5 filter
7		1	0364926	Pivot joint paint LW NPS1/4"-18 filter
8		1	9992528	Loctite 270
9		1	9992695	Castor oil
10		1	9992698	Vaseline white PHHV II

**Note:**

All reusable parts should be cleaned thoroughly using a suitable solvent.

Assembly

1. Lightly grease o-ring (3) using castor oil and push it onto gasket (4). Insert the gasket assy. into connection piece.

Note

By assembling do not damage gasket (4)

2. Screw adjuster screw (2) into connection piece using Loctite 270.

Note

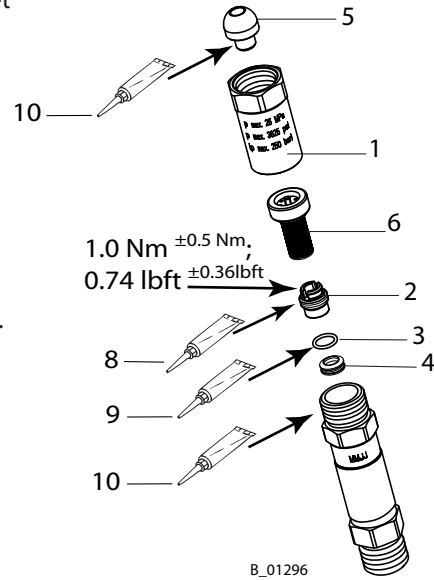
Do not thighten fully the adjuster screw.

3. Tighten the adjuster screw (2) using a torque wrench to a torque of $1.5 \text{ Nm} \pm 0.5 \text{ Nm}$; $1.11 \text{ lbft} \pm 0.37 \text{ lbft}$
4. Put the assembled part for 30 minutes at 40°C ; 104°F in a oven.

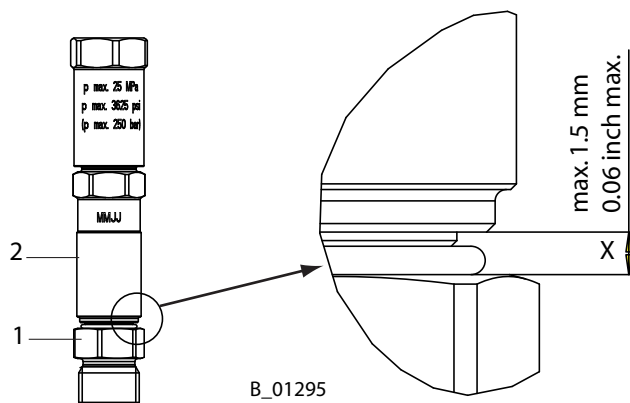
Note

The part must be placed in the oven on the filter housing (1).

5. Press nipple (5) into filter housing (1). Place the edge filter (6) into connection piece. Screw the filter housing (1) and pivot joint together. (Lightly grease the thread with vaseline)
6. Check the pivot joint for leaks using solvent or spray oil and a max. pressure of 25 MPa ; 250 bar ; 3626 psi or 16 MPa ; 160 bar ; 2320 psi .

**Dimensional accuracy:**

If the distance „x“ between pinhead (1) and distance piece (2) is larger than 1.5 mm; 0.06 inches, the pivot joint must be replaced.



9 ACCESSORIES

9.1 AIRCOAT NOZZLES ACF3000

Part-No.	Marking	Size mm; inch	Spraying angle	Recommended gunfilter		
				red (200 Meshes)	yellow (100 Meshes)	60 Meshes
0379107	07/10	0.007-0.18	10°			
0379207	07/20	0.007-0.18	20°			
0379209	09/20	0.009-0.23	20°			
0379309	09/30	0.009-0.23	30°			
0379409	09/40	0.009-0.23	40°			
0379509	09/50	0.009-0.23	50°			
0379609	09/60	0.009-0.23	60°			
0379111	11/10	0.011-0.28	10°			
0379211	11/20	0.011-0.28	20°			
0379311	11/30	0.011-0.28	30°			
0379411	11/40	0.011-0.28	40°			
0379511	11/50	0.011-0.28	50°			
0379611	11/60	0.011-0.28	60°			
0379113	13/10	0.013-0.33	10°			
0379213	13/20	0.013-0.33	20°			
0379313	13/30	0.013-0.33	30°			
0379413	13/40	0.013-0.33	40°			
0379513	13/50	0.013-0.33	50°			
0379613	13/60	0.013-0.33	60°			
0379813	13/80	0.013-0.33	80°			
0379115	15/10	0.015-0.38	10°			
0379215	15/20	0.015-0.38	20°			
0379315	15/30	0.015-0.38	30°			
0379415	15/40	0.015-0.38	40°			
0379515	15/50	0.015-0.38	50°			
0379615	15/60	0.015-0.38	60°			
0379815	15/80	0.015-0.38	80°			
0379217	17/20	0.017-0.43	20°			
0379317	17/30	0.017-0.43	30°			
0379417	17/40	0.017-0.43	40°			
0379517	17/50	0.017-0.43	50°			
0379617	17/60	0.017-0.43	60°			
0379817	17/80	0.017-0.43	80°			

Recommended edge filter	
Application	
Natural paint	200 Meshes
Transparent paint Oil	200 Meshes
Synthetic resin paint PVC paint	200 Meshes
Paint, undercoat Priming paint Filler	100 Meshes
Filler Rustproofing paint	100 Meshes
Rustproofing paint Latex paint	60 Meshes

Part-No.	Marking	Size inch-mm	Spraying angle	Recommended gunfilter		Application	
				Recommended gunfilter	Recommended edge filter		
0379219	19/20	0.019-0.48	20°	white (50 Meshes)	yellow (100 Meshes)	Rustproofing paint Latex paint	
0379319	19/30	0.019-0.48	30°				
0379419	19/40	0.019-0.48	40°				
0379519	19/50	0.019-0.48	50°				
0379619	19/60	0.019-0.48	60°				
0379819	19/80	0.019-0.48	80°				
0379221	21/20	0.021-0.53	20°		white (50 Meshes)	yellow (100 Meshes)	Distemper paint Zinc dust coating Rustproofing paint Mica paint
0379421	21/40	0.021-0.53	40°				
0379521	21/50	0.021-0.53	50°				
0379621	21/60	0.021-0.53	60°				
0379821	21/80	0.021-0.53	80°				
0379423	23/40	0.023-0.58	40°				
0379623	23/60	0.023-0.58	60°			60 Meshes	
0379823	23/80	0.023-0.58	80°				
0379425	25/40	0.025-0.64	40°				
0379625	25/60	0.025-0.64	60°				
0379825	25/80	0.025-0.64	80°				
0379427	27/40	0.027-0.69	40°				
0379627	27/60	0.027-0.69	60°				
0379827	27/80	0.027-0.69	80°				
0379429	29/40	0.029-0.75	40°				
0379629	29/60	0.029-0.75	60°				
0379829	29/80	0.029-0.75	80°				
0379431	31/40	0.031-0.79	40°				
0379631	31/60	0.031-0.79	60°				
0379831	31/80	0.031-0.79	80°				
0379435	35/40	0.035-0.90	40°				
0379635	35/60	0.035-0.90	60°				
0379835	35/80	0.035-0.90	80°				

9.2 AIR CAPS

Part No.	Description
0364911	Air cap HV (blue) for high viscosity paints
0364910	Air cap LV (red) for low viscosity paints



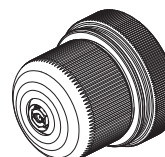
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9.3 AIRCOAT-NOZZLE ROUND ACR3000

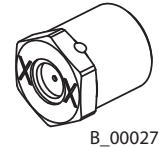
Part No.	Description
0371011	Nozzle ACR3000 R11
0371012	Nozzle ACR3000 R12
0371013	Nozzle ACR3000 R13
0371014	Nozzle ACR3000 R14
0371015	Nozzle ACR3000 R15
0371016	Nozzle ACR3000 R16
0371017	Nozzle ACR3000 R17
0371018	Nozzle ACR3000 R18
0371019	Nozzle ACR3000 R19
0371020	Nozzle ACR3000 R20
0371021	Nozzle ACR3000 R21
0371022	Nozzle ACR3000 R22



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9.3.1 NOZZLE INSERTS RXX

Part No.	Description	Marking	Jet width**
0132720	Nozzle insert R11	11	ca. 250; 9.84
0132721	Nozzle insert R12	12	ca. 250; 9.84
0132722	Nozzle insert R13	13	ca. 250; 9.84
0132723	Nozzle insert R14	14	ca. 250; 9.84
0132724	Nozzle insert R15	15	ca. 250; 9.84
0132725	Nozzle insert R16	16	ca. 250; 9.84
0132726	Nozzle insert R17	17	ca. 250; 9.84
0132727	Nozzle insert R18	18	ca. 250; 9.84
0132728	Nozzle insert R19	19	ca. 250; 9.84
0132729	Nozzle insert R20	20	ca. 250; 9.84
0132730	Nozzle insert R21	21	ca. 250; 9.84
0132731	Nozzle insert R22	22	ca. 250; 9.84

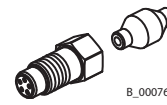


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** Jet width in mm; inch at a distance of 30 cm; 11.8 inches from the object and at a pressure of 10 MPa; 100 bar; 1450 psi, synthetic resin paint, 20 DIN4 seconds

9.3.2 NOZZLE SCREW JOINT ASSY.

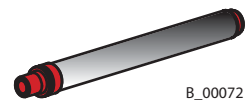
Part No.	Description
0132922	Nozzle screw joint assy.



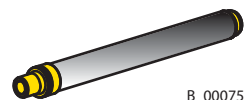
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9.4 FILTERS FOR SPRAY GUN

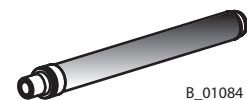
Part No. for 1 piece	Part No. for 10 pcs.	Filter Type	Meshsize	For use with nozzle sizes:
0034383	0097022	Gun filter (red)	200	0.007" - 0.015"
0043235	0097023	Gun filter (yellow)	100	0.015" - 0.019"
0034377	0097024	Gun filter (white)	50	0.017" - 0.021"



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B_01084

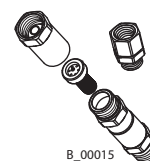


9.5 SWIVEL FOR GUNS WITHOUT FILTERS

Part No.	Description
0364930	Set swivel M16x1,5 for paint connection and air connection.
0364931	Set swivel NPSM1/4" for paint connection and air connection.
0364925	Swivel material connection M16x1,6 with filter 100 meshes
0364926	Swivel material connection NPSM1/4" with filter 100 meshes
3204605	Filter for swivel 100 meshes
3204604	Filter for swivel 60 meshes
9999002	Filter for swivel 200 meshes



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B_00015



B_00014



B_00014



B_00019



B_00019



B_00019

9.6 HOSES

Part No.	Description
9984564	HP-Twin hose M16x1.5; 7.5 m; DN 4 mm; 27 MPa; 270 bar, M16x1.5; 24.6 ft; ID 0.16 in; 3916 psi for guns with filter
9984565	HP-Twin hose M16x1.5; 7.5 m; DN 4 mm; 27 MPa; 270 bar, M16x1.5; 24.6 ft; ID 0.16 in; 3916 psi for guns without filter
9984509	HP-Twin hose M16x1.5; 7.5 m; DN 4 mm; 27 MPa; 270 bar, M16x1.5; 24.6 ft; ID 0.16 in; 3916 psi for extension HP twin hose
9984609	HP-Twin hose NPSM1/4"; 7.5 m; DN 4 mm; 27 MPa; 270 bar, NPSM1/4"; 24.6 ft; ID 0.16 in; 3916 psi for extension HP twin hose
9984664	HP-Twin hose NPSM1/4"; 7.5 m; DN 4 mm; 27 MPa; 270 bar, NPSM1/4"; 24.6 ft; ID 0.16 in; 3916 psi for guns with filter
9984665	HP-Twin hose NPSM1/4"; 7.5 m; DN 4 mm; 27 MPa; 270 bar, NPSM1/4"; 24.6 ft; ID 0.16 in; 3916 psi for guns without filter

**9.7 MISCELLANEOUS**

Part No.	Description
9997001	Nozzle cleaning brush
8612001	Nozzle cleaning needle set (12 pieces)
0364940	Service kit GM3000AC for gun with filter
0364941	Service kit GM3000AC for gun without filter
9985720	Double nipple R1/4" for extension for air hose
0123446	Double nipple M16x1.5 for extension for material hose
0367560	Double connection NPSM1/4" for extension for material hose
0364966	Conversion kit 16 MPa; 160 bar; 2320 psi GM3000AC Note: Valid for gun-serial-number „02001“ and higher

10 SPARE PARTS

10.1 HOW TO ORDER SPARE PARTS?

Always supply the following information to ensure delivery of the right spare part:

Part Number, description and quantity

The quantity need not be the same as the number given in the „Quantity“ column. This number merely indicates how many of the respective parts are used in each subassembly.


The following information is also required to ensure smooth processing of your order:

- Address for the invoice
- Address for delivery
- Name of the person to be contacted in the event of any queries
- Type of delivery required (air freight or mail, sea route or overland route, etc.)

Marks in spare parts lists

Note to column „K“ in the following spare parts lists.

- ◆ = Wearing parts
Note: No liability is assumed for wearing parts
- = Not part of standard equipment, available, however, as additional extra.

	! WARNING
	<p>Incorrect maintenance/repair! Risk of injury and damage to the equipment</p> <p>→ Repairs and part replacement may only be carried out by specially trained staff or a WAGNER service center.</p> <p>→ Before all work on the unit and in the event of work interruptions:</p> <ul style="list-style-type: none"> - Switch off the energy/compressed air supply. - Relieve the pressure from the spray gun and unit. - Secure the spray gun against actuation. <p>→ Observe the operating and service instructions when carrying out all work.</p>

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10.2 SPARE PARTS LIST GM 3000AC WITH FILTER**Spare parts list GM 3000AC with filter**

Item	K	Qty	Part-No.	Description
1		1	0364927	Gun housing pre-assembled filter
2		1	0364921	Aircap nut assy.
4	◆★	1	0364922	Valve seat assy.
7	◆★	1	0364920	Valve rod (assembled)
8		1	0364923	Swivel joint (paint) M16x1.5 assy.
8		1	0364924	Swivel joint (paint) NPSM1/4" assy.
9		1	0364347	Fan air control knob
10		1	0364346	Tension nut 25 MPa; 250 bar; 3626 psi
10		1	0364366	Tension nut 16MPa; 160 bar; 2320 psi
11		1	0364327	Trigger
12		1	0364350	Safety catch
13		1	0364317	Air connection
14		1	0364348	Atomizing air plug
15		1	0364337	Retaining screw
16		1	0364349	Housing cover
17	◆★	1	0364301	Seal (distributor)
18	◆★	1	0364328	Seal (nozzle)
19	◆★	1	0364318	Seal (air valve)
22	◆★	1	0364345	Shaft collar
23	◆★	1	0364340	Seal (filter)
24		1	9998580	Pressure spring (air)
25		1	9998581	Pressure spring (paint)
26		1	9900808	Screw M3x8 mm; 0.31 inches long
28		2	9907146	Screw M4x10 mm; 0.39 inches long
29		1	0364938	Swivel joint (air) R1/4"
30	◆★	1	9971390	O-ring
31	◆★	1	9971353	O-ring
32	◆★	1	9971182	O-ring
33	◆	1	00.....	Gun filter (see chapter 9.4)
50		1	0364309	Valve tappet
51		1	0364910	Air cap LV (red)
51		1	0364911	Air cap HV (blue)
52	◆★	1	0364319	Seal (tappet)

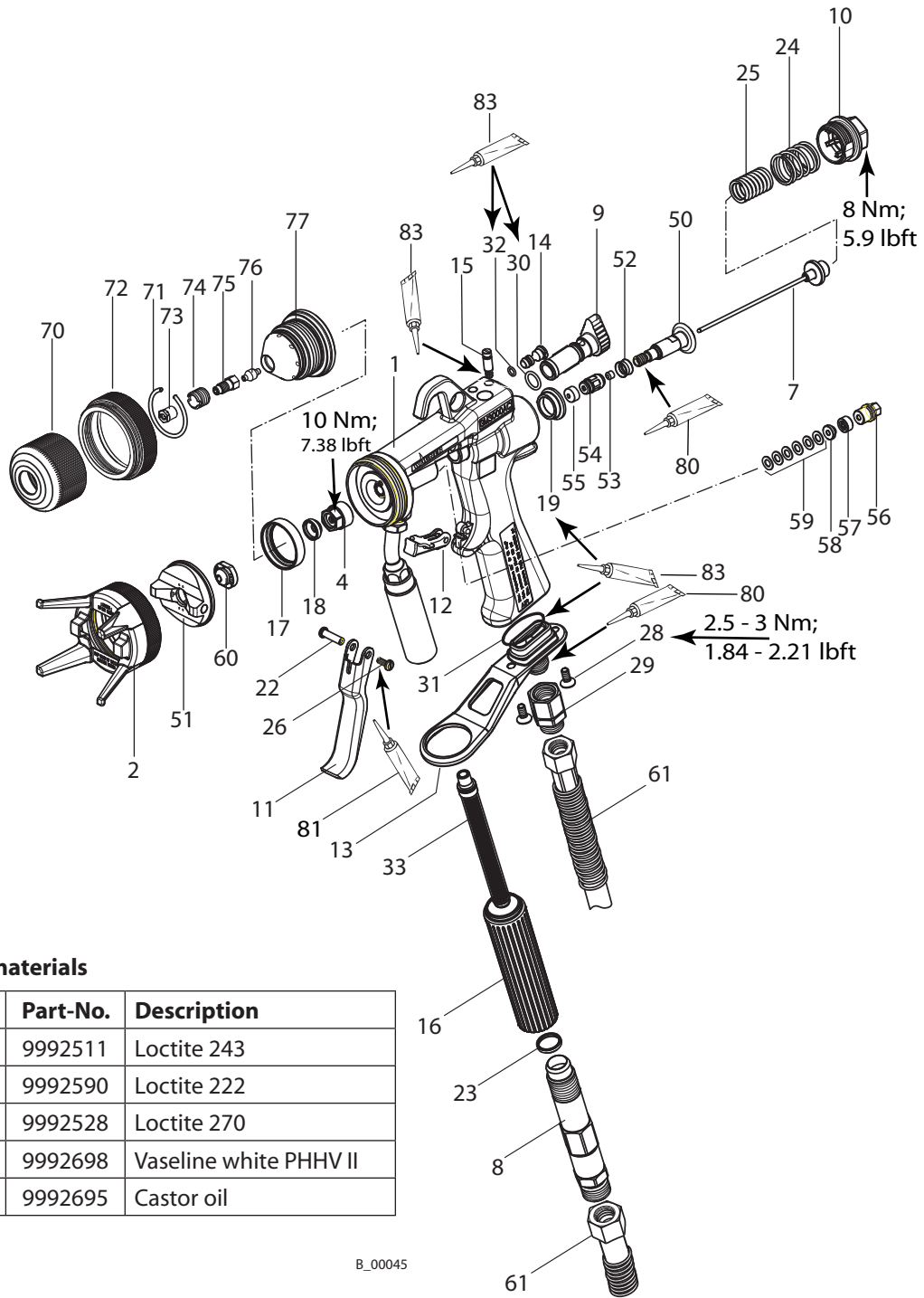
◆ = Wearing part

★ = Included in service-kit

● = Not part of standard equipment for the spray gun. but is available as an optional extra



GM 3000AC with filter



Assembly materials

Item	K	Part-No.	Description
80	●	9992511	Loctite 243
81	●	9992590	Loctite 222
82	●	9992528	Loctite 270
83	●	9992698	Vaseline white PHHV II
84	●	9992695	Castor oil

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Spare parts list GM 3000AC with filter

Item	K	Qty	Part-No.	Description
53	◆★	1	0364320	Seal (rod)
54		1	0364311	Tappet cap
55	◆★	1	0364338	Slide cap
56		1	0364305	Packing screw
57	◆★	1	0364306	Packing
58		1	0364307	Pressure ring
59	★	1	0335707	Spring plate set
60	◆●	1	0379...	AC-nozzle ../.. see chapter 9.1
61	◆●	1	9984564	HP-twin-hose M16x1.5; 7.5 m; DN 4 mm; 27 MPa; 270 bar, M16x1.5; 24.6 ft; ID 0.16 inches; 3916 psi
70	●	1	0364400	Nozzle nut
71	●	1	9922722	Snap ring
72	●	1	0364302	Union nut
73	◆●	1	0132...	Nozzle insert ACR... (see chapter 9.3.)
74	●	1	0132351	Nozzle screw joint holder
75	◆●	1	0132516	Nozzle screw joint assy.
76	◆●	1	0128327	Sealing nipple
77	●	1	0364401	Nozzle housing
	●	1	0364940	Service kit GM3000AC with filter

◆ = Wearing part

★ = Included in service-kit

● = Not part of standard equipment for the spray gun. but is available as an optional extra

10.3 SPARE PARTS LIST GM 3000AC WITHOUT FILTER**Spare parts list GM3000 AC without filtre**

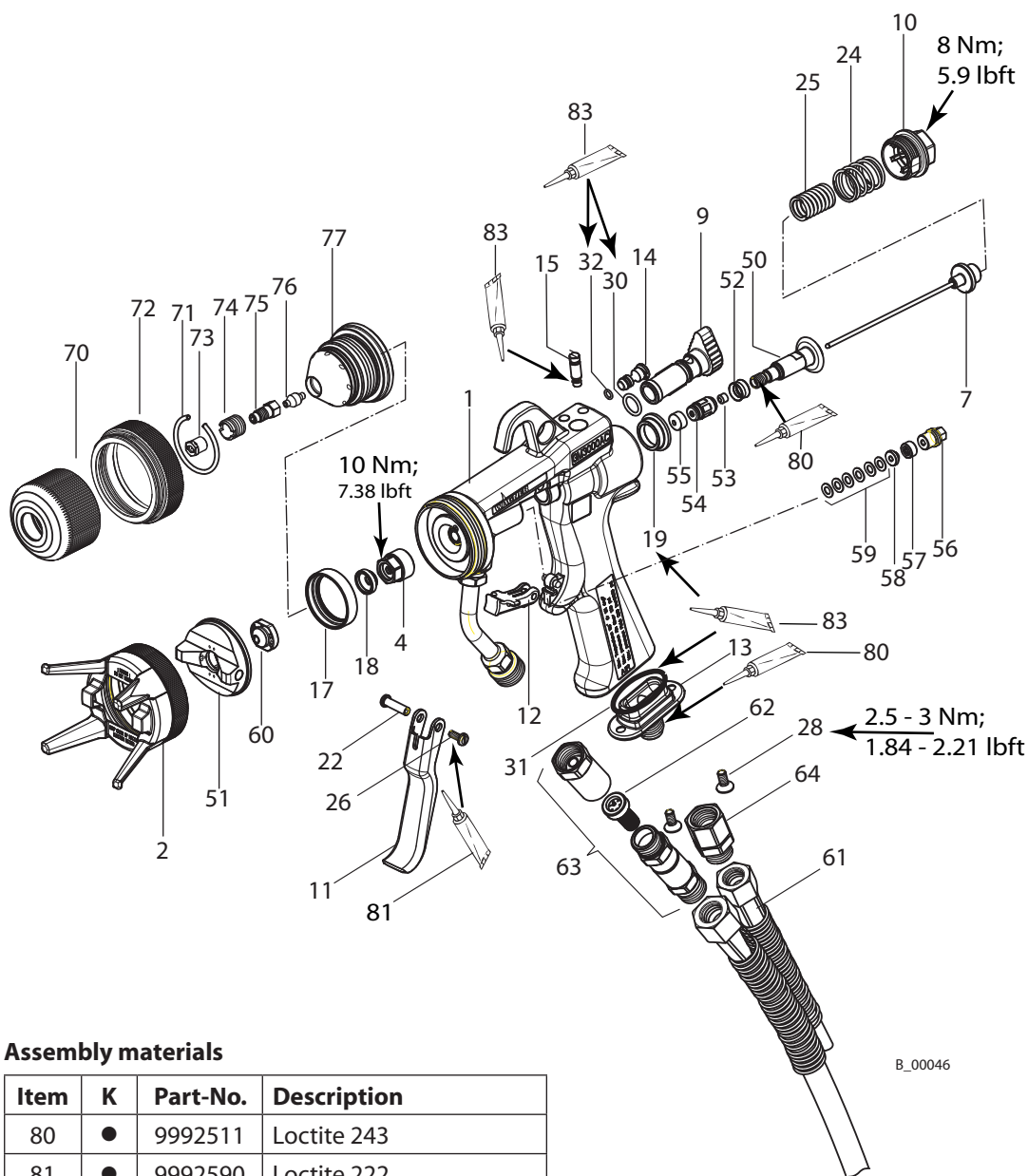
Item	K	Qty	Part-No.	Description
1		1	0364928	Gun housing pre-assembled M16x1.5
1		1	0364929	Gun housing pre-assembled NPSM1/4"
2		1	0364921	Aircap nut assy.
4	◆★	1	0364922	Valve seat assy.
7	◆★	1	0364920	Valve rod (assembled)
9		1	0364347	Fan air control knob
10		1	0364346	Tension nut 25 MPa; 250 bar; 3626 psi
10		1	0364366	Tension nut 16MPa; 160 bar; 2320 psi
11		1	0364327	Trigger
12		1	0364350	Safety catch
13		1	0364361	Air connection LW
14		1	0364348	Atomizing air plug
15		1	0364337	Retaining screw
17	◆★	1	0364301	Seal (distributor)
18	◆★	1	0364328	Seal (nozzle)
19	◆★	1	0364318	Seal (air valve)
22	◆	1	0364345	Shaft collar
24		1	9998580	Pressure spring (air)
25		1	9998581	Pressure spring (paint)
26		1	9900808	Screw M3x8 mm; 0.31 inches long
28		2	9907146	Screw M4x10 mm; 0.39 inches long
30	◆★	1	9971390	O-ring
31	◆★	1	9971353	O-ring
32	◆★	1	9971182	O-ring
50		1	0364309	Valve tappet
51		1	0364910	Air cap LV (red)
51		1	0364911	Air cap HV (blue)
52	◆★	1	0364319	Seal (tappet)
53	◆★	1	0364320	Seal (rod)
54		1	0364311	Tappet cap
55	◆★	1	0364338	Slide cap
56		1	0364305	Packing screw
57	◆★	1	0364306	Packing
58		1	0364307	Pressure ring

◆ = Wearing part

★ = Included in service-set

● = Not part of standard equipment for the spray gun. but is available as an optional extra

GM3000 AC without filtre



B_00046

Assembly materials

Item	K	Part-No.	Description
80	●	9992511	Loctite 243
81	●	9992590	Loctite 222
82	●	9992528	Loctite 270
83	●	9992698	Vaseline white PHHV II
84	●	9992695	Castor oil

Spare parts list GM3000 AC without filtre

Item	K	Qty	Part-No.	Description
59	★	1	0335707	Spring plate set
60	◆●	1	0379...	AC-nozzle ../..see chapter 9.1
61	◆●	1	9984565	HP-twin-hose M16x1.5; 7.5 m; DN 4 mm; 27 MPa; 270 bar, M16x1.5; 24.6 ft; ID 0.16 in; 3916 psi
62	◆●	1	3204...	Filter see chapter 9.4
63	●	1	0364925	Swivel mat. connection M16x1.5
63	●	1	0364926	Swivel mat. connection NPSM1/4"
64	●	1	0364938	Swivel joint (air) R1/4"
70	●	1	0364400	Nozzle nut
71	●	1	9922722	Snap ring
72	●	1	0364302	Union nut
73	◆●	1	0132...	Nozzle insert ACR... (see chapter 9.3)
74	●	1	0132351	Nozzle screw joint holder
75	◆●	1	0132516	Nozzle screw joint assy.
76	◆●	1	0128327	Sealing nipple
77	●	1	0364401	Nozzle housing
	●	1	0364941	Service kit GM3000AC without filter

◆ = Wearing part

★ = Included in service-set

● = Not part of standard equipment for the spray gun. but is available as an optional extra

10.4 SPARE PARTS LIST GM 3000AC-H WITHOUT FILTER**Spare parts list GM 3000AC-H without filtre**

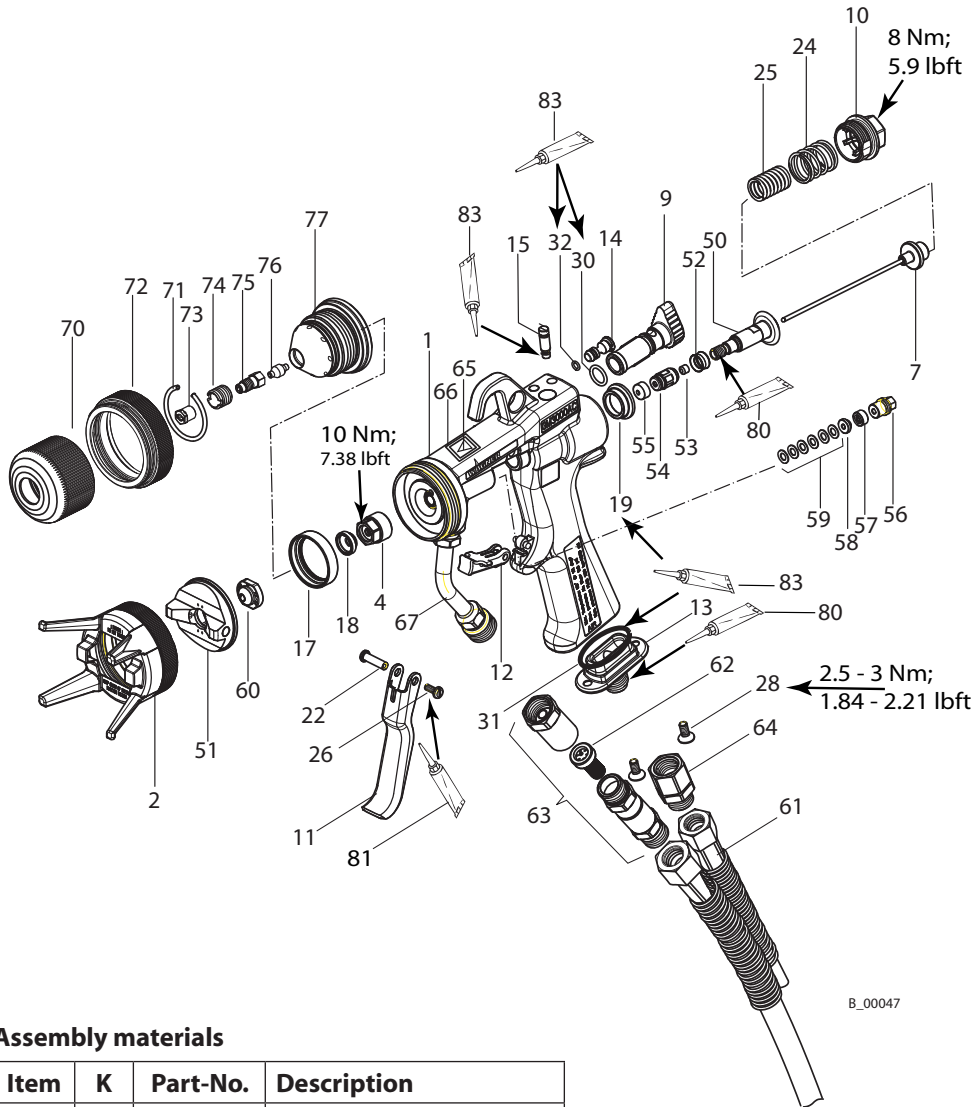
Item	K	Qty	Part-No.	Description
1		1	0364934	Gun housing AC-H pre-assembled M16x1.5
2		1	0364921	Aircap nut assy.
4	◆★	1	0364922	Valve seat assy.
7	◆★	1	0364920	Valve rod (assembled)
9		1	0364347	Fan air control knob
10		1	0364346	Tension nut 25 MPa; 250 bar; 3626 psi
11		1	0364327	Trigger
12		1	0364350	Safety catch
13		1	0364361	Air connection LW
14		1	0364348	Atomizing air plug
15		1	0364337	Retaining screw
17	◆★	1	0364301	Seal (distributor)
18	◆★	1	0364328	Seal (nozzle)
19	◆★	1	0364318	Seal (air valve)
22	◆	1	0364345	Shaft collar
24		1	9998580	Pressure spring (air)
25		1	9998581	Pressure spring (paint)
26		1	9900808	Screw M3x8 mm; 0.31 inches long
28		2	9907146	Screw M4x10 mm; 0.39 inches long
30	◆★	1	9971390	O-ring
31	◆★	1	9971353	O-ring
32	◆★	1	9971182	O-ring
50		1	0364309	Valve tappet
51		1	0364911	Air cap HV (blue)
52	◆★	1	0364319	Seal (tappet)
53	◆★	1	0364320	Seal (rod)
54		1	0364311	Tappet cap
55	◆★	1	0364338	Slide cap
56		1	0364305	Packing screw
57	◆★	1	0364306	Packing
58		1	0364307	Pressure ring
59	★	1	0335707	Spring plate set
60	◆●	1	0379...	AC-nozzle ../.. see chapter 9.1

◆ = Wearing part

★ = Included in service kit

● = Not part of standard equipment for the spray gun. but is available as an optional extra

GM 3000AC-H without filtre



Assembly materials

Item	K	Part-No.	Description
80	●	9992511	Loctite 243
81	●	9992590	Loctite 222
82	●	9992528	Loctite 270
83	●	9992698	Vaseline white PHHV II
84	●	9992695	Castor oil

Spare parts list GM 3000AC-H without filtre

Item	K	Qty	Part-No.	Description
61	◆●	1	9984565	HP-twin-hose M16x1.5; 7.5 m; DN 4 mm; 27 MPa; 270 bar, M16x1.5; 24.6 ft; ID 0.16 inches; 3916 psi
62	◆●	1	00...	Filter see chapter 9.4
63	◆●	1	0364925	Swivel mat. connection M16x1.5
64	◆●	1	0364938	Swivel joint (air) R1/4"
65		1	9998910	Instruction sticker
66		1	9998911	Protection sticker
67		1	9982606	Protection hose 70 mm; 2.75 inches
70	●	1	0364400	Nozzle nut
71	●	1	9922722	Snap ring
72	●	1	0364302	Union nut
73	◆●	1	0132...	Nozzle insert ACR... (see chapter 9.3)
74	●	1	0132351	Nozzle screw joint holder
75	◆●	1	0132516	Nozzle screw joint assy.
76	◆●	1	0128327	Sealing nipple
77	●	1	0364401	Nozzle housing
	●	1	0364941	Service kit GM3000AC without filter

◆ = Wearing part

★ = Included in service kit

● = Not part of standard equipment for the spray gun. but is available as an optional extra

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GM 3000 AC

Die Kombination von innovativer Düse und zwei verschiedenen Luftkappen macht die GM 3000 AC zu einem Allrounder bei der Verarbeitung aller wasser- und lösemittelhaltigen Lacke (wie z.B. Acryllack, 2 K-Lack, DD-Lack), Beizen und Lasuren.

The combination of innovative nozzle and two different air caps makes the GM 3000 AC to an high grade allrounder for the application of all water based and solvent based lacquers (such as e.g. acrylic-, 2 component-, DD lacquer), stains and varnishes.

The best features at-a-glance:

Das Beste auf einen Blick:

- hohe Beschichtungsgeschwindigkeit
- gleichmäßiger Materialauftrag
- weich auslaufende Randzonen
- weniger Overspray im Vergleich zum Airless- und Luftspritzen
- gute Zerstäubung schon ab 60 bar Materialdruck
- deshalb geringerer Düsen- und Geräteverschleiß
- ergonomische Pistole mit vielen Extras für hohen Arbeitskomfort, wie die Wendedüse und das hand-lösbare Filtergehäuse

- high coating speed
- uniform application of material
- soft run-out at the edges of zones
- less overspray than with Airless and air-spraying
- good atomisation right from a material pressure of 60 bar
- thus less nozzle and equipment wear
- the ergonomic gun with many extras for a higher level of working convenience, such as the reversible nozzle and the manually released filter housing

Das Ergebnis: beste Verarbeitungseigenschaften für eine hochwertige Oberflächenbeschichtung.

The result: the best application characteristics for high-grade surface coating.



Für pneumatische Kolbenpumpen
For pneumatic piston pumps



Für 2K-Anlagen
For 2-K-units



Für Membran-Anlagen
For diaphragm pumps

!

Erkundigen Sie sich nach weiteren Produkten aus unserem Hause: Niederdruckluftspritzgeräte, Kolben- und Membranpumpen, 2K-Anlagen, Putzspritzanlagen, Materialförderlogistik ...und vieles mehr.

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